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**Xu et al.**

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(54) **ACOUSTIC RESONATOR**

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**H03H 9/13** (2006.01)

**H03H 9/02** (2006.01)

(52) **U.S. Cl.**

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(Continued)

(58) **Field of Classification Search**

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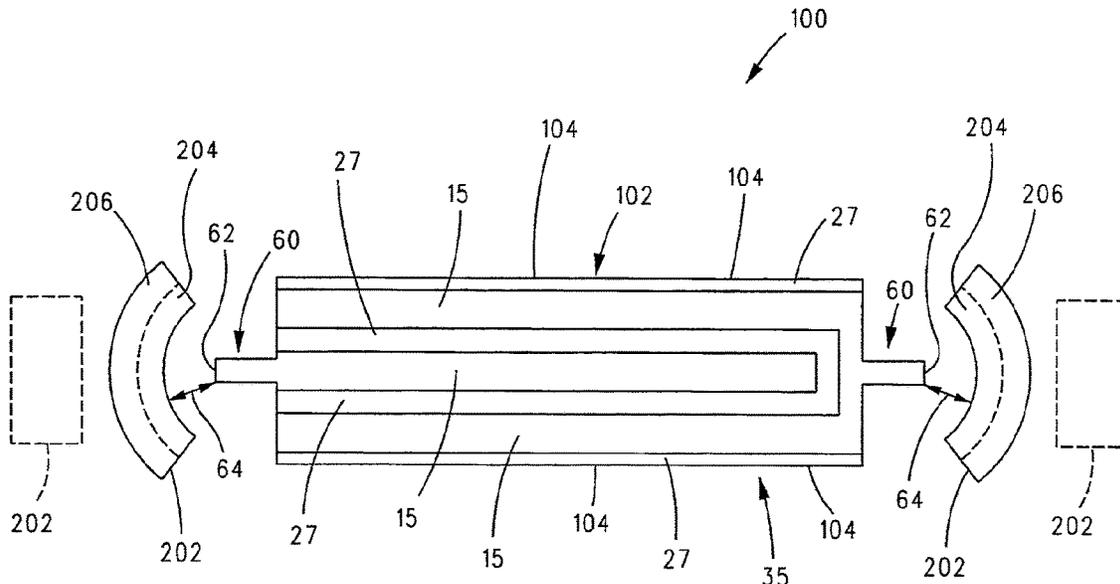
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(57) **ABSTRACT**

An acoustic resonator includes a piezoelectric stack including a piezoelectric layer having a top surface and a bottom surface, a top electrode layer disposed above the top surface, and a bottom electrode layer disposed below the bottom surface. A number of acoustic wave reflectors are disposed on a side of the bottom electrode layer opposite the piezoelectric layer. Each acoustic wave reflector includes a high acoustic impedance layer and may include a low acoustic impedance layer. The acoustic resonator may include a tether that extends laterally to a stacking direction of the layers of the piezoelectric stack. A supporting structure may be coupled to the tether opposite the acoustic resonator for anchoring the acoustic resonator. A mirror, one or more phononic crystals, or both may be positioned on proximate the tether opposite the acoustic resonator to avoid resonant waves from exiting the acoustic resonator in use.

**20 Claims, 14 Drawing Sheets**



- (52) **U.S. Cl.**  
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(2013.01); **H03H 9/02448** (2013.01); **H03H**  
**9/13** (2013.01); **H03H 9/175** (2013.01)

- (58) **Field of Classification Search**  
CPC ... H03H 9/02448; H03H 9/02102; H03H 9/13  
See application file for complete search history.

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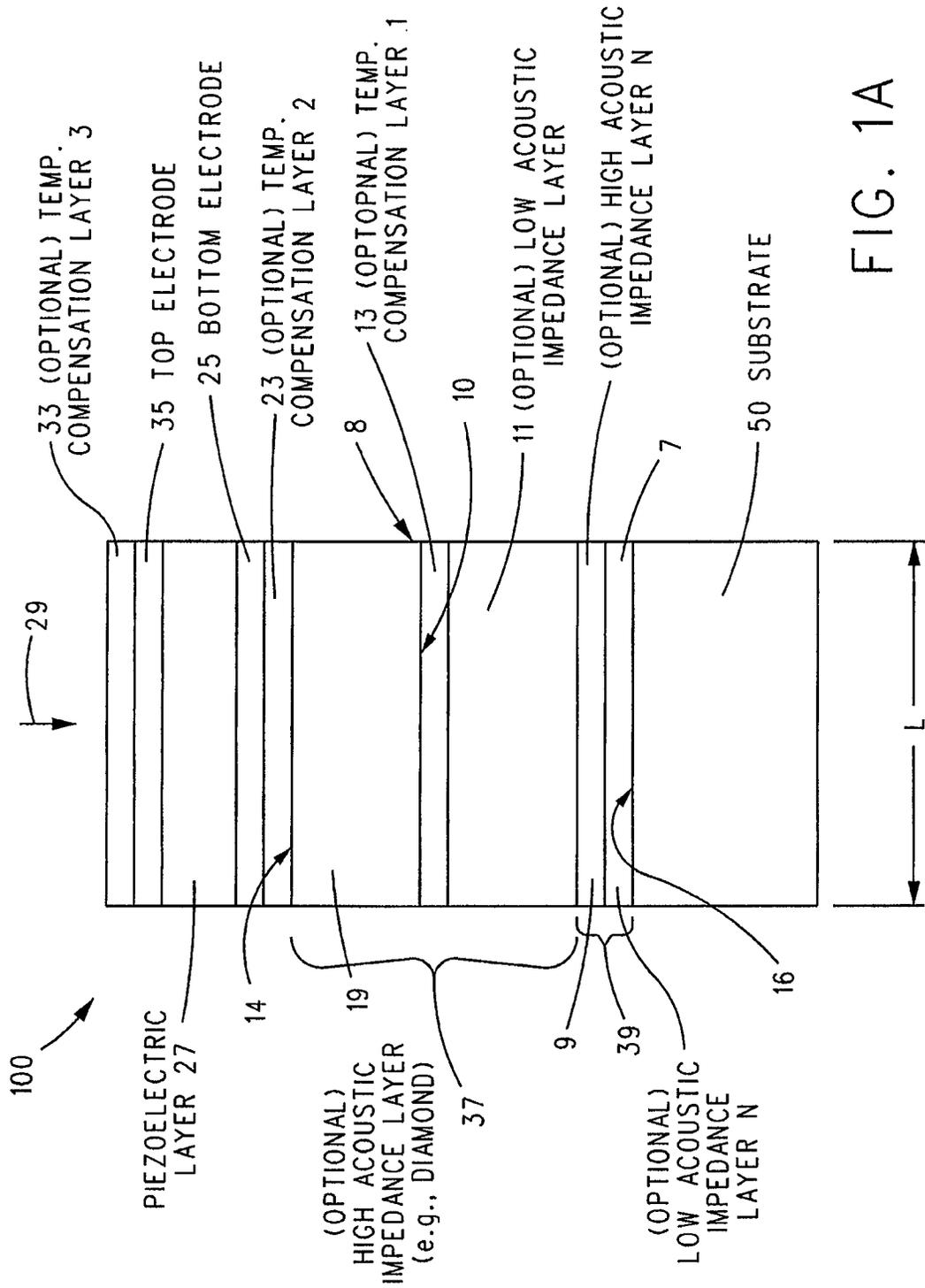


FIG. 1A

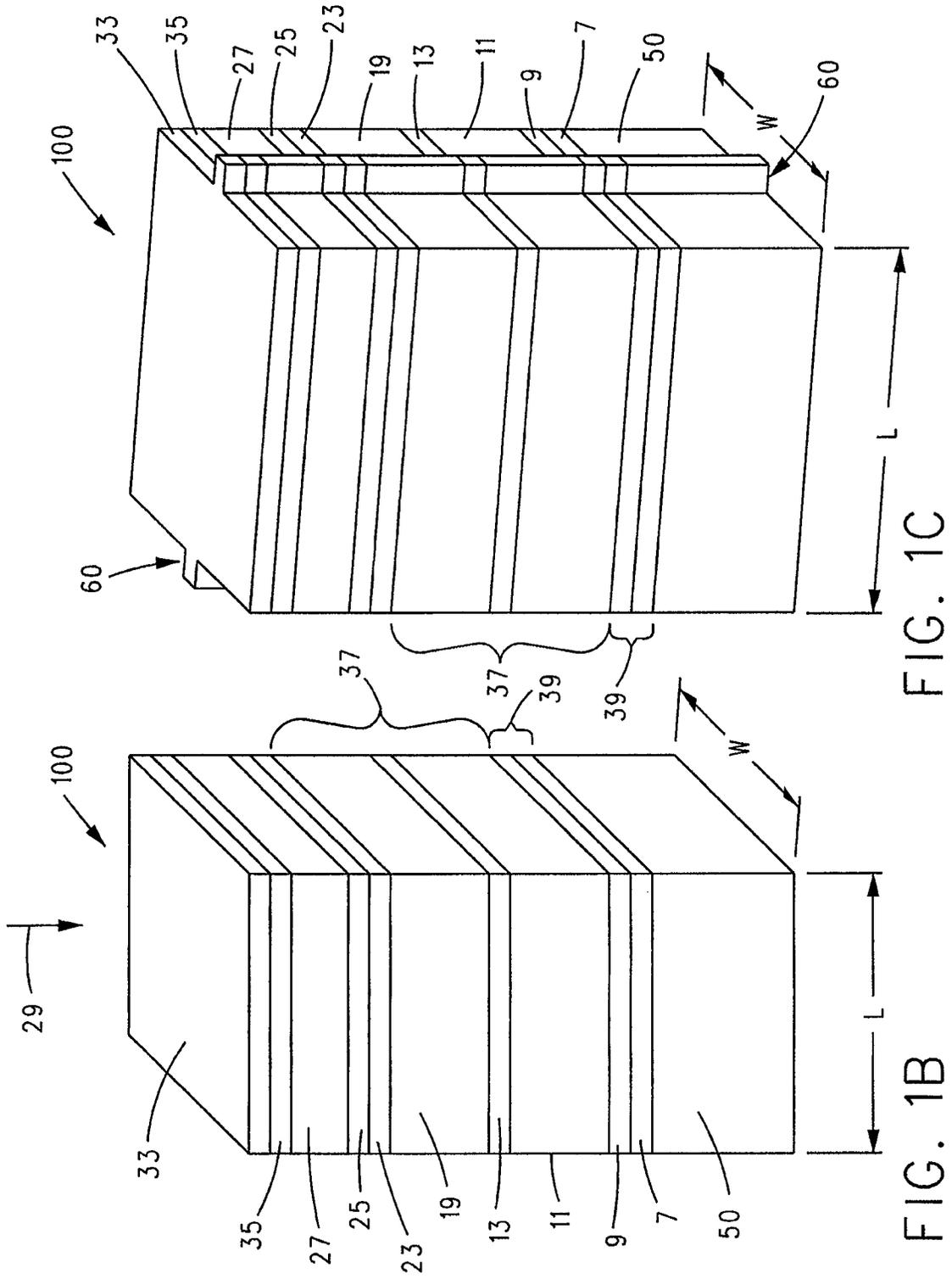


FIG. 1C

FIG. 1B

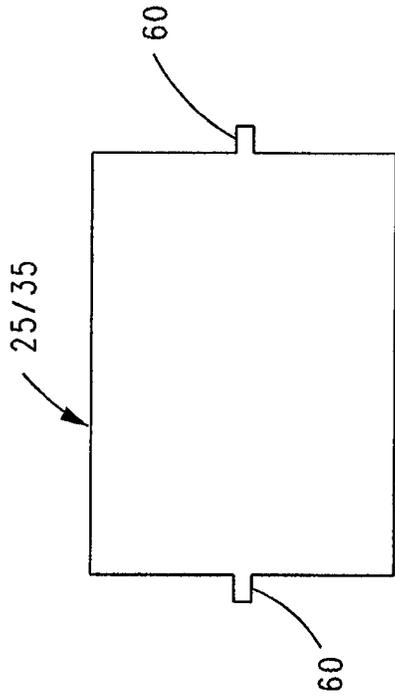


FIG. 2A

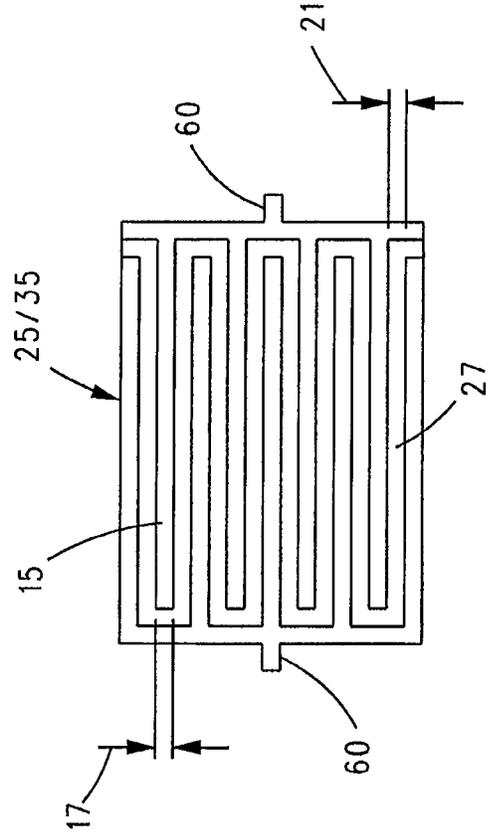


FIG. 2B

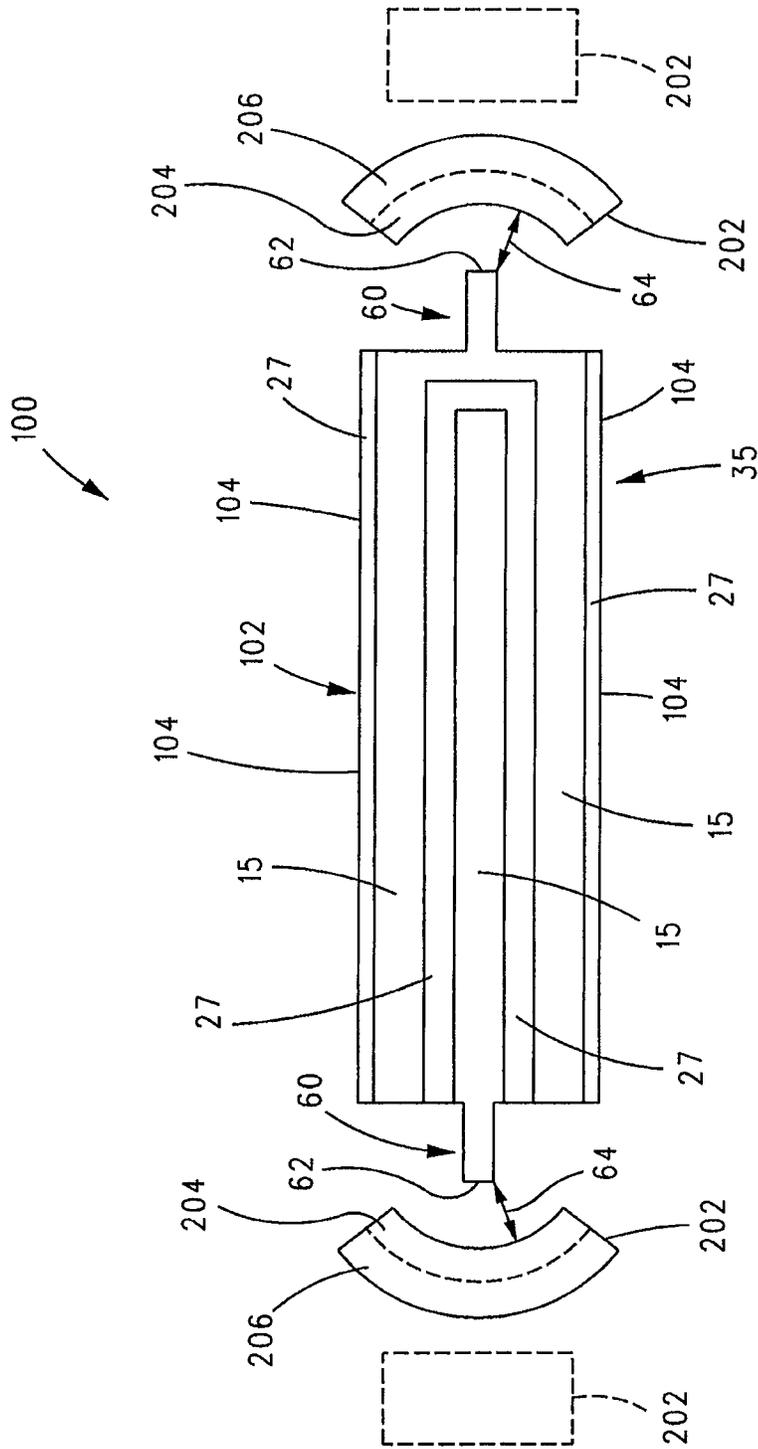


FIG. 3

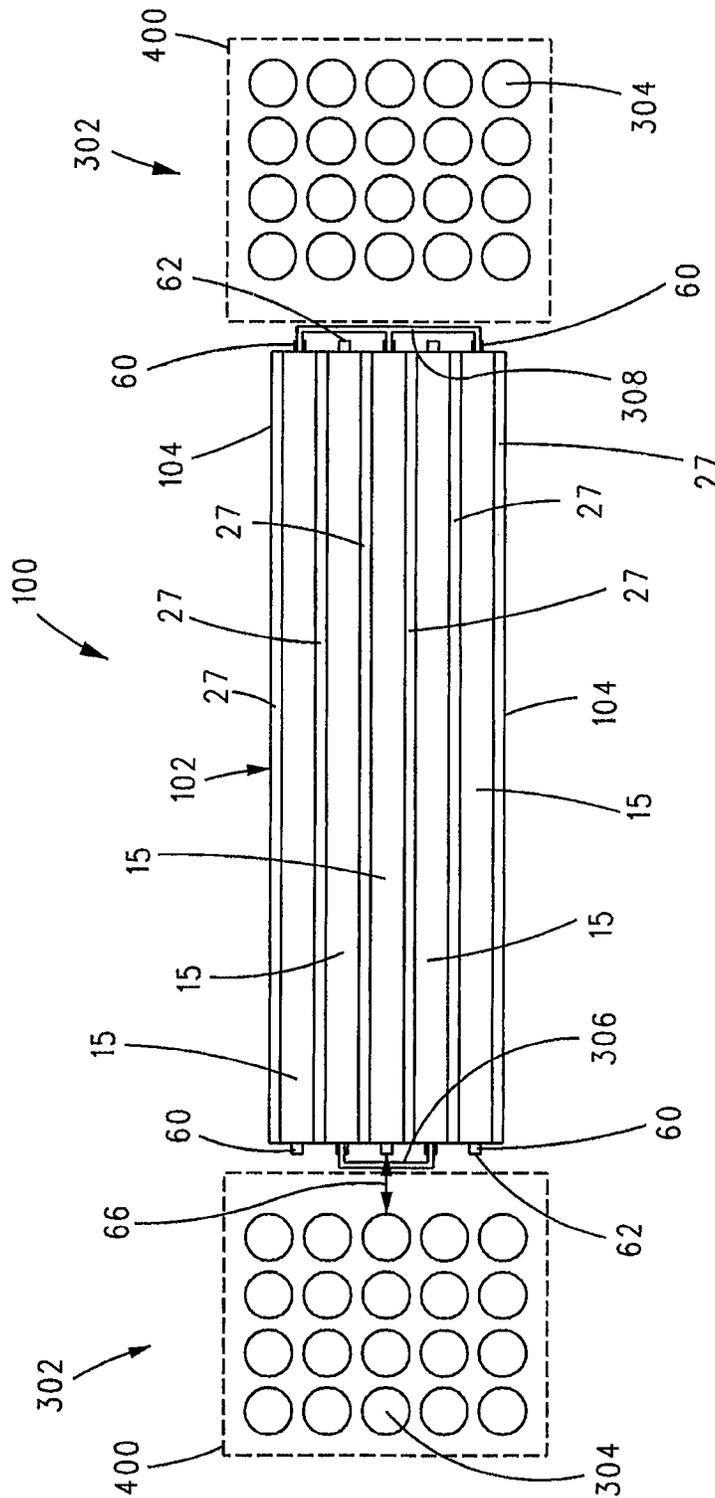
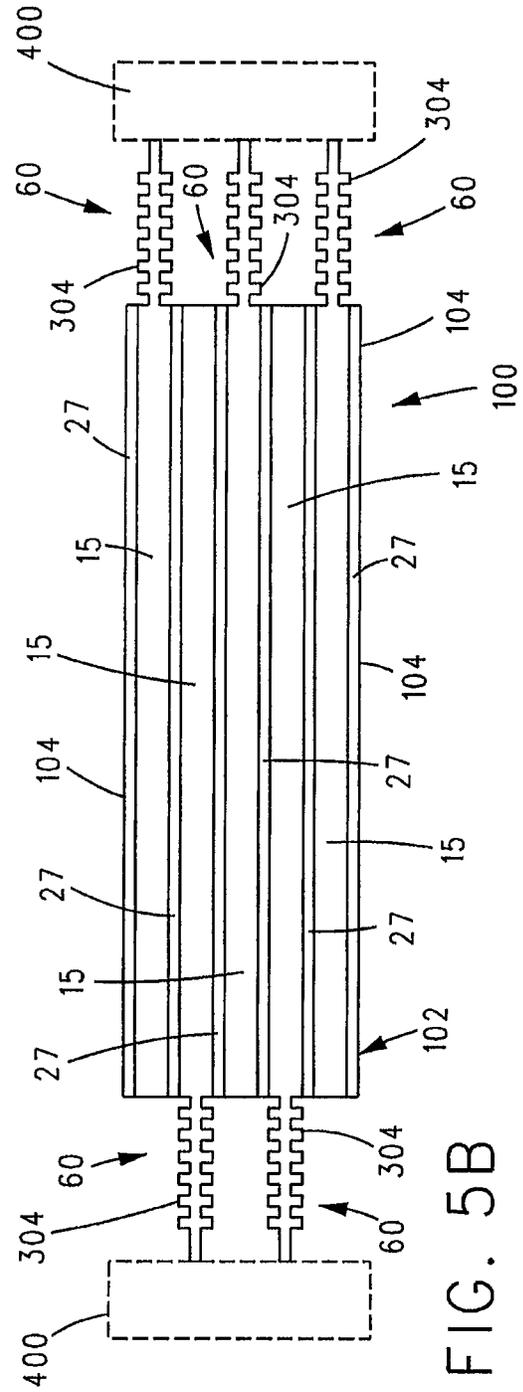
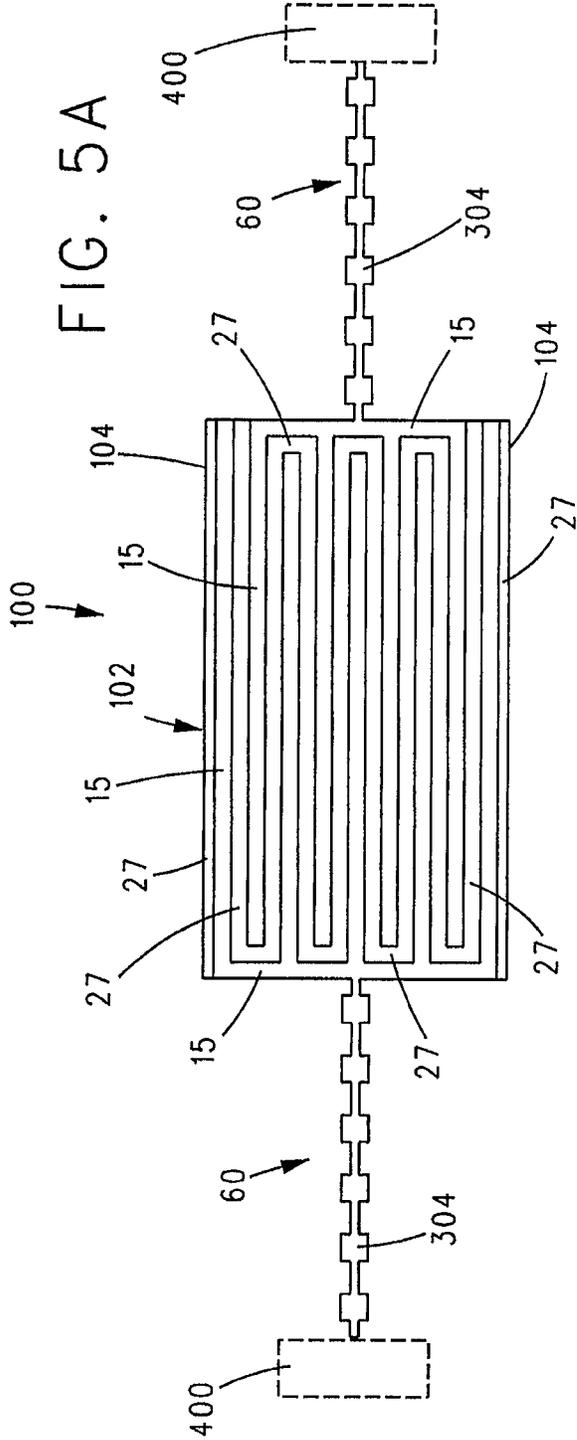


FIG. 4



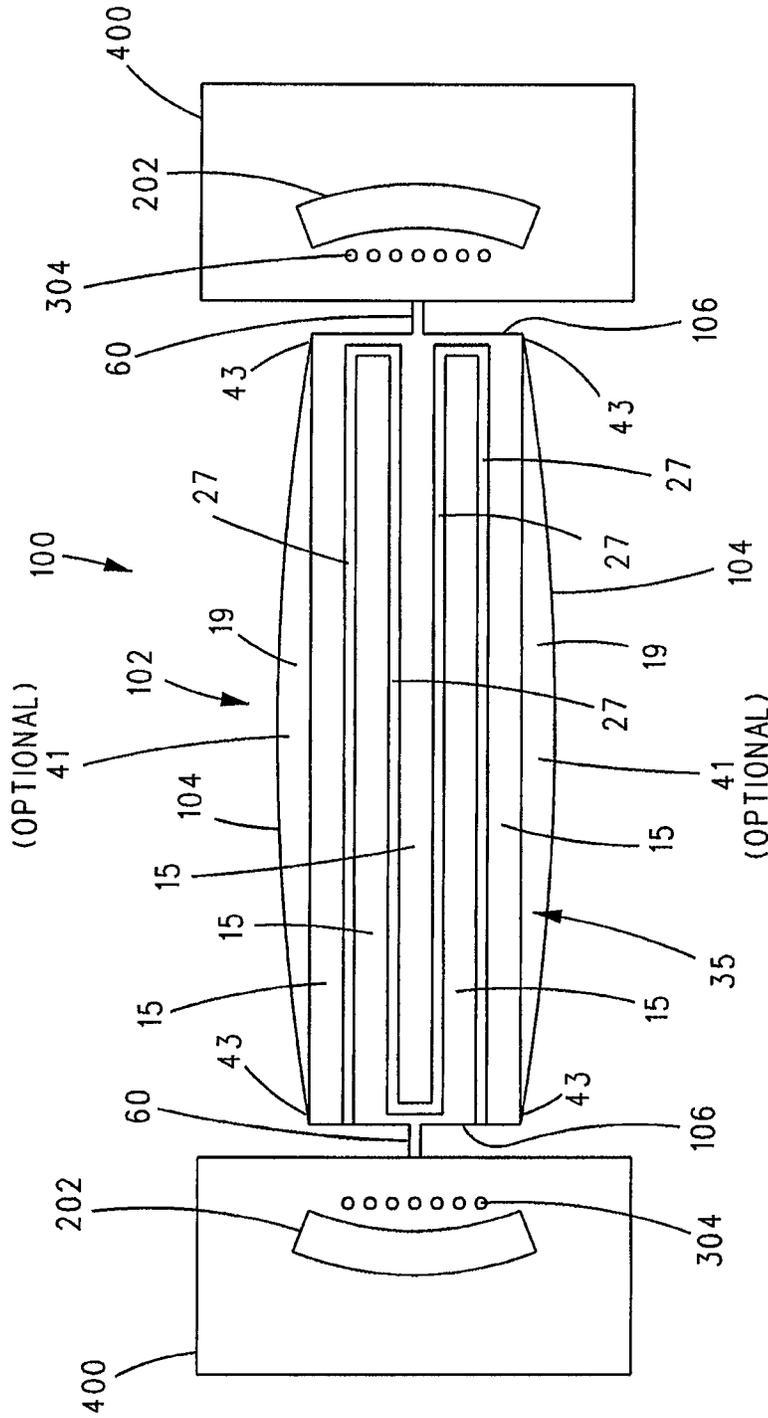


FIG. 6

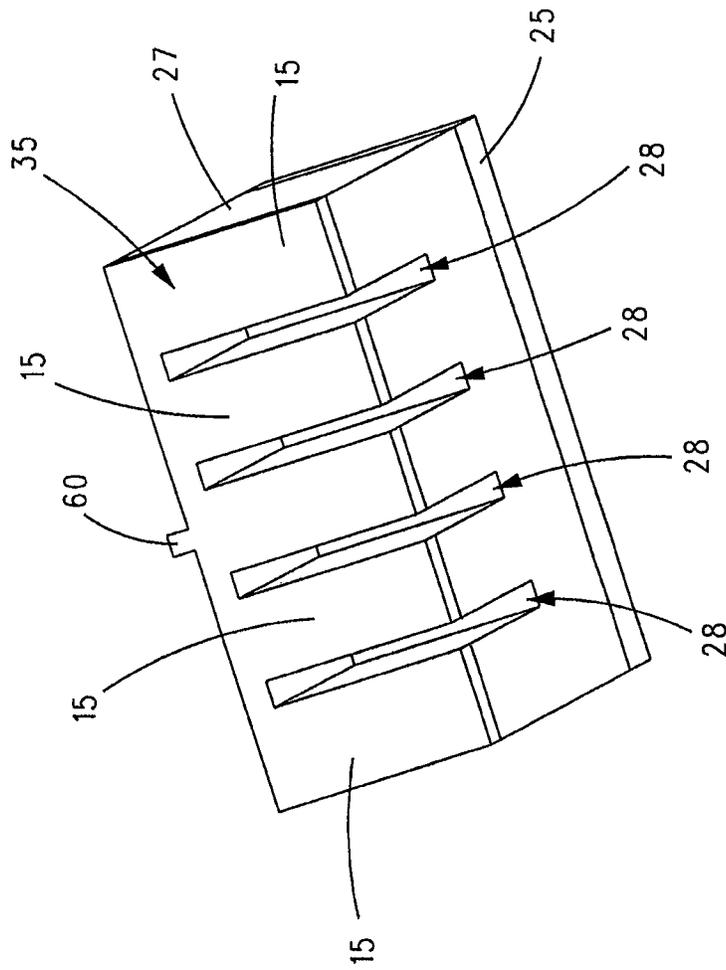


FIG. 7

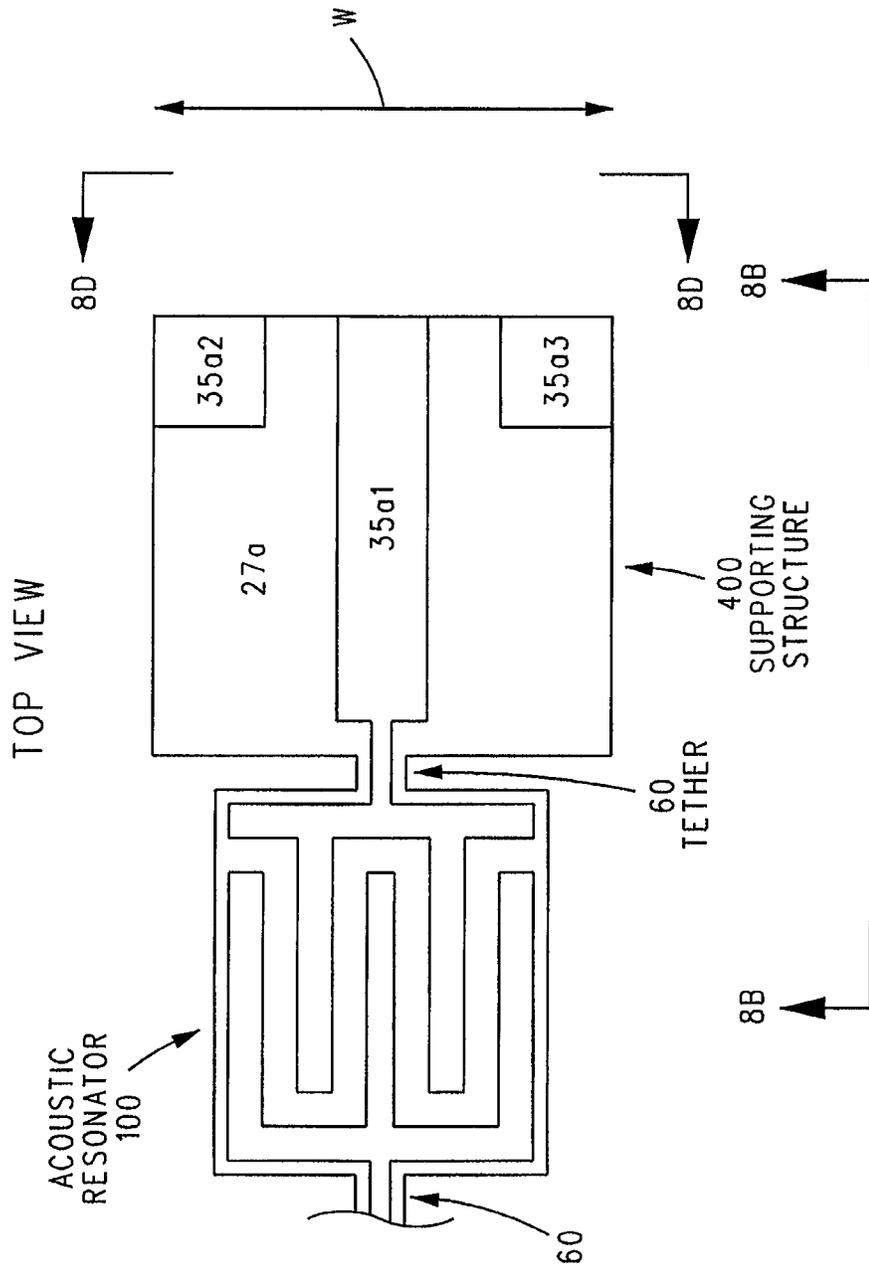


FIG. 8A

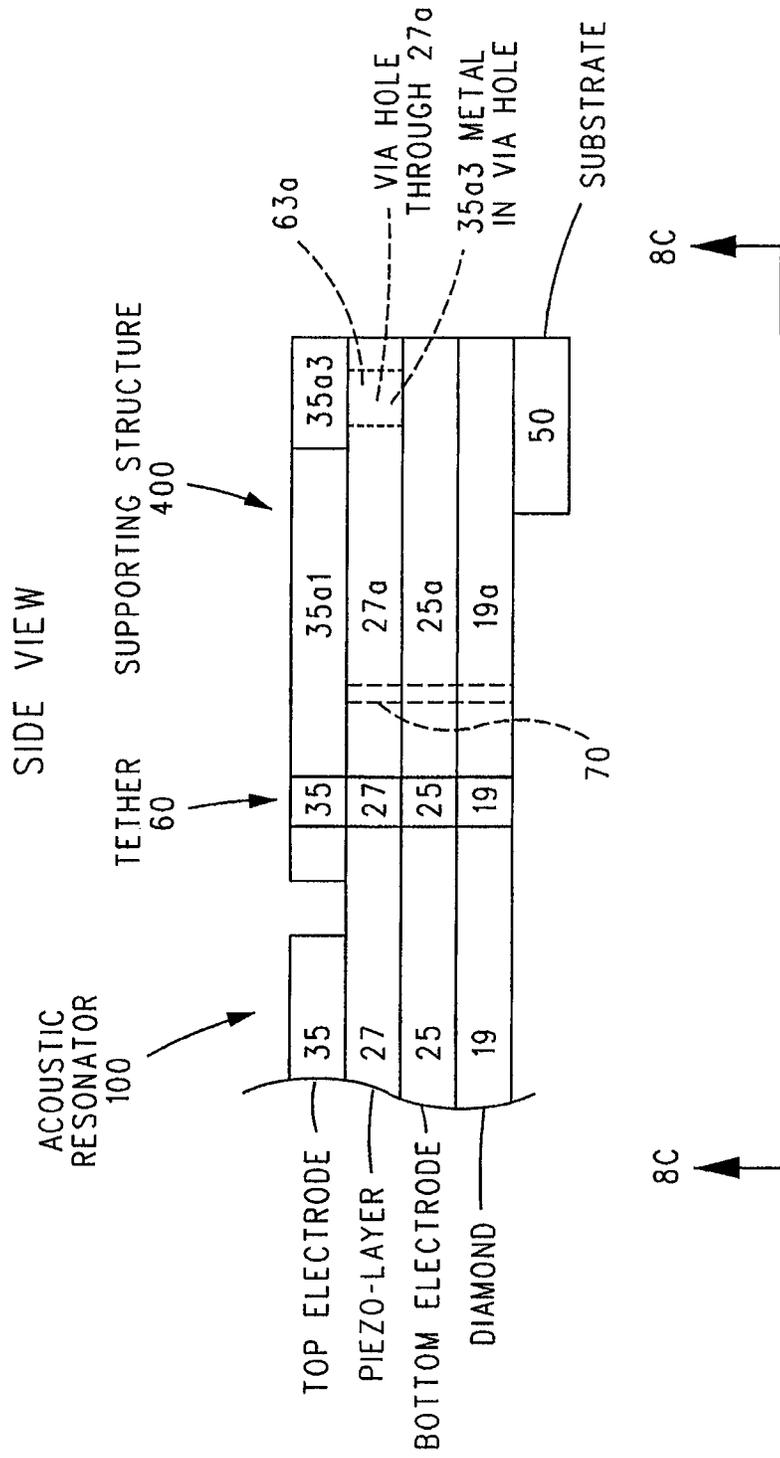


FIG. 8B

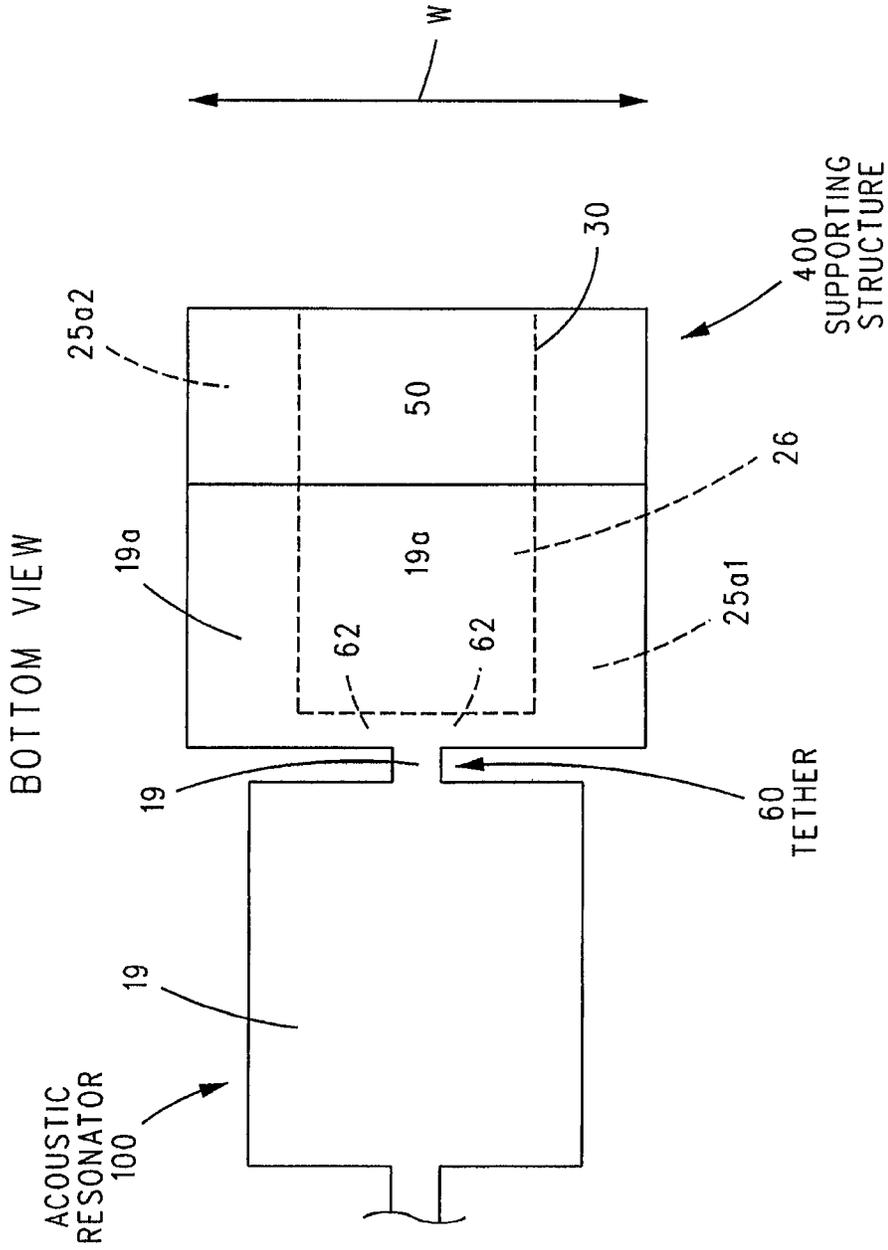


FIG. 8C

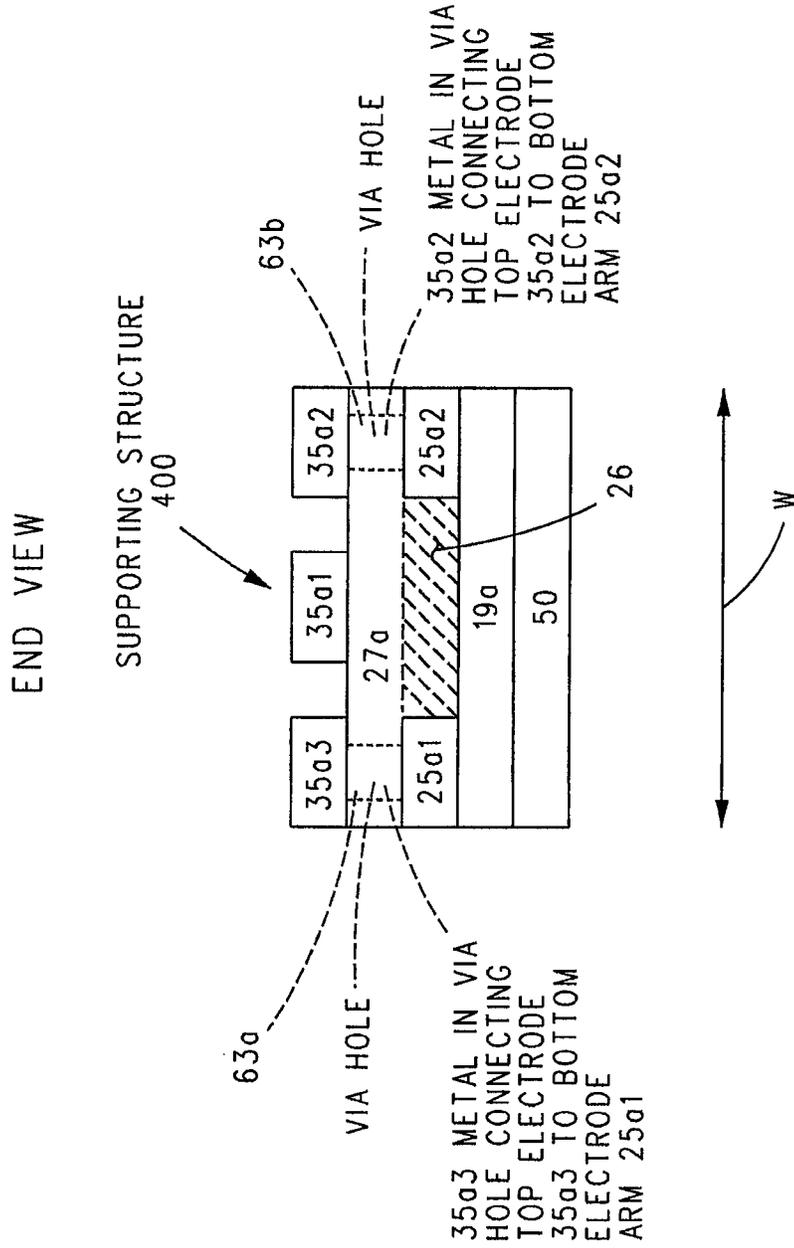


FIG. 8D

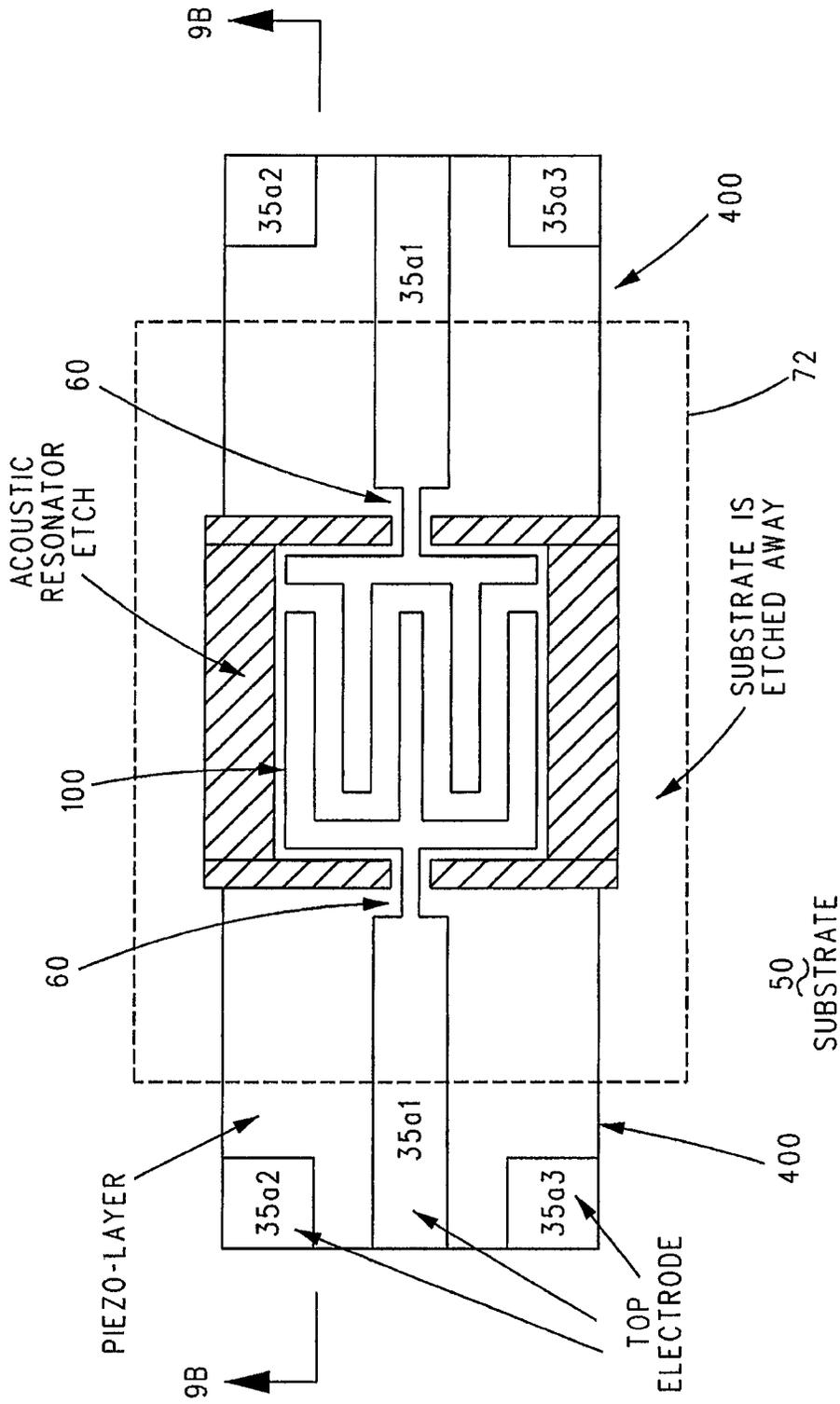


FIG. 9A

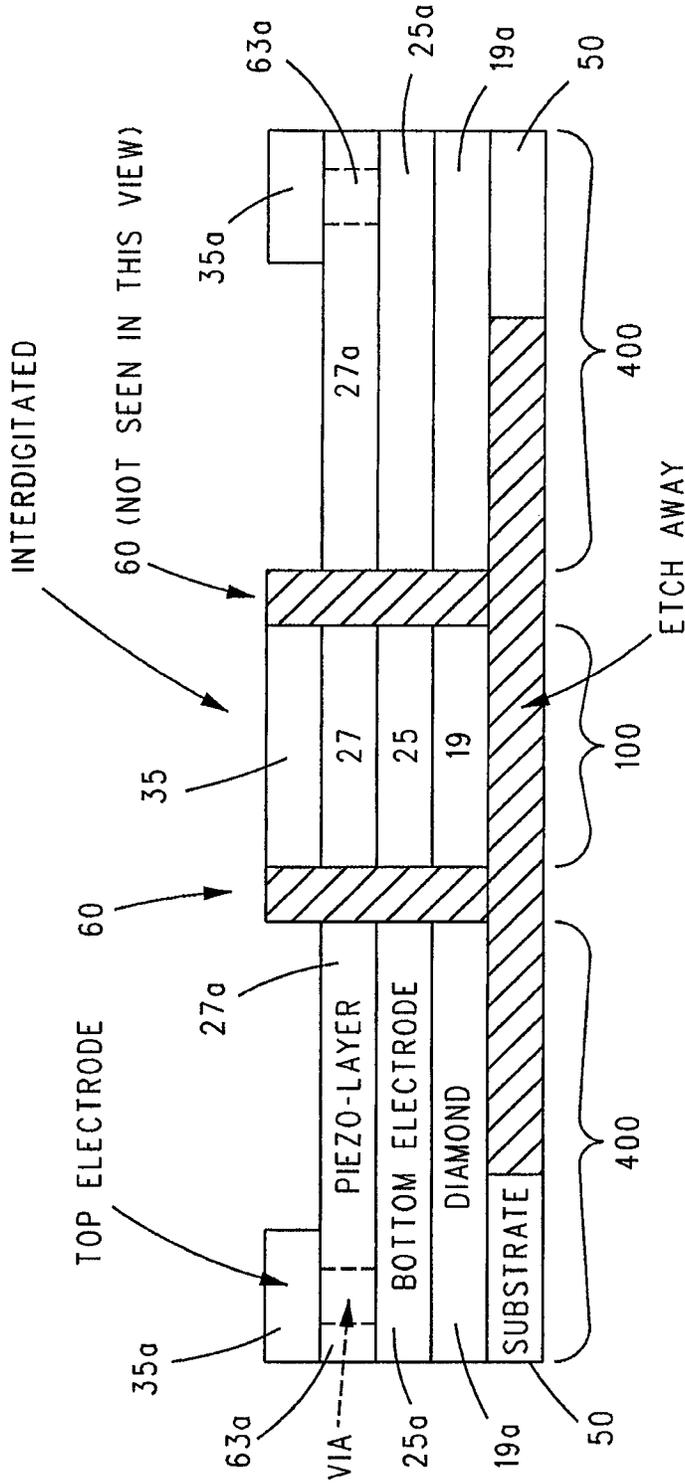


FIG. 9B

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**ACOUSTIC RESONATOR****CROSS REFERENCE TO RELATED APPLICATION**

This application claims the benefit of U.S. provisional patent application No. 62/597,662, filed Dec. 12, 2017, the contents of which are incorporated herein by reference.

**BACKGROUND OF THE INVENTION****Field of the Invention**

The present invention relates to an acoustic resonator comprising electrodes, a piezoelectric layer, and acoustic reflectors.

**Description of Related Art**

In radio frequency (RF) communications, RF signals can be filtered with surface-acoustic-wave (SAW) filters and bulk-acoustic-wave (BAW) filters. Film-bulk-acoustic-resonators (FBAR) and solid-mounted-resonators (SMR) are two types of BAW filters that are piezoelectric-driven micro-electro-mechanical-system (MEMS) devices that enable current RF communications, capable of resonating at a relatively high frequency with a relatively low insertion loss, as compared to SAW filter devices. These BAW filters comprise a piezoelectric layer, a top electrode, and a bottom electrode. The resonance frequency of these BAW filters is thickness-based or depends on the thickness of the thin films of the resonant body, e.g., the resonance frequency increases with decreasing thickness of the thin films of the resonant body. The film thickness of the resonant bodies is critical and has to be precisely controlled for a desirable resonance frequency. Industrially, it can be expensive and time consuming to trim different areas of the wafer with ion-milling to achieve a high level of thickness uniformity to attain a reasonable yield of FBAR and SMR for a targeted or specified RF frequency.

Future RF communication systems are expected to utilize frequencies from currently a few hundred MHz to 1.8 GHz for cellular communications (and 2.5 GHz for Wi-Fi communications) to 3-6 GHz (sub-6 GHz), and possibly, all the way up to 100 GHz. In order to be used at these frequencies, the film thickness for FBAR and SMR-based RF filters need to be reduced in order to increase the resonance frequency. Furthermore, the product of frequency and Quality-Factor (or Q) of FBAR and SMR devices are typically constant, which means that an increase in resonance frequency will lead to a decrease in Q. Decrease in Q is undesirable, particularly given that the state of art of FBAR and SMR's Q is approaching the theoretical limit (3,500) at a frequency 2.45 GHz or below. Therefore, doubling the frequency will lead to a reduction of Q value by a half, e.g., to 1,750, which is not desirable for making a RF devices such as a RF filter, a RF resonator, a RF switch, a RF oscillator, etc.

**SUMMARY OF THE INVENTION**

Generally, provided is an improved acoustic resonator.

In some non-limiting embodiments or examples, an acoustic resonator in accordance with principles of the present invention can comprise a piezoelectric layer disposed between a pair of electrodes.

In some non-limiting embodiments or examples, the acoustic resonator can include one or a plurality of acoustic

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wave reflectors, each of which can include a layer of a high acoustic impedance material and, optionally, a layer of a low acoustic impedance material. The high acoustic impedance layer can have an acoustic impedance ( $Z_a$ )  $\geq 60 \times 10^6$  N·s/m<sup>3</sup>, and the low acoustic impedance layer can have an acoustic impedance ( $Z_b$ )  $\leq 65 \times 10^6$  N·s/m<sup>3</sup>. In some non-limiting embodiments or examples, the layer of high acoustic impedance material may be a layer of diamond having an acoustic impedance of about  $630 \times 10^6$  N·s/m<sup>3</sup>. In some non-limiting embodiments or examples, the number of layers of the acoustic wave reflector may be  $\geq 2$ ,  $\geq 10$ ,  $\geq 20$ ,  $\geq 50$ , and  $\geq 100$ .

In some non-limiting embodiments or examples, the layer of high acoustic impedance material may comprise one or more of the following: a condensed or solid-phase material; ceramic; glass; a polymer; a crystal, a mineral, etc. In some non-limiting embodiments or examples, the solid-phase material may include one or more of the following: platinum, palladium, tungsten, molybdenum, chromium, titanium, and tantalum. In some non-limiting embodiments or examples, the solid-phase material may include one or more elements from one or more of Group IIIA, IVA, IB, IIB, IIIB, IVB, VB, VIB, VIIB, and VIIIB of the periodic table of the elements.

In some non-limiting embodiments or examples, the optional layer of a low acoustic impedance material may comprise a vacuum or a gas-phase material. In some non-limiting embodiments or examples, the gas-phase material may include one or more of the following: air hydrogen, nitrogen, carbon dioxide, carbon monoxide, oxygen, one of group VIIIA inert gases such as helium, neon, argon, krypton, xenon, etc., an organic material such as a hydrocarbon material or its substituted derivatives with different functional group, or a mixture comprising any of the foregoing.

In some non-limiting embodiments or examples, the layer of a low acoustic impedance material may comprise a liquid-phase material.

In some non-limiting embodiments or examples, the layer of a low acoustic impedance material may comprise a solid-phase material that may have a low acoustic impedance between  $1 \times 10^6$  (e.g., ivory at  $1.4 \times 10^6$  N·s/m<sup>3</sup>) and  $30 \times 10^6$  N·s/m<sup>3</sup> (e.g., alumina/sapphire at  $25.5$  N·s/m<sup>3</sup>). In some non-limiting embodiments or examples, the solid-phase material can be comprised of metal having a low acoustic impedance between  $1 \times 10^6$  (e.g., alkali metal potassium K at  $1.4 \times 10^6$  N·s/m<sup>3</sup>) and  $100 \times 10^6$  N·s/m<sup>3</sup> (e.g., tungsten W  $99.72 \times 10^6$  N·s/m<sup>3</sup>).

In an example, each electrode can be a continuous layer or a patterned layer. In an example, the patterned layer can include a comb-shaped or interdigitated array of electrical conductor lines having between proximate pairs of electrical conductor lines a portion of the piezoelectric layer visible. In an example, the width of each electrical conductor line and the width of each portion of the piezoelectric layer visible therebetween can be between 0.00001 mm and 1 mm; 0.0001 mm and 0.1 mm; or 0.0001 mm and 0.01 mm. In an example, a ratio of the width of an electrical conductor line to the portion of the piezoelectric layer visible between proximate electrical conductor lines may vary, ranging from 0.001 to 1,000; 0.01 to 100; or 0.1 to 10.

In some non-limiting embodiments or examples, the spacing between a pair of proximate electrical conductor lines may vary from 1% to 99% of the width of the electrical conductor line having the smallest width. In some non-limiting embodiments or examples, the interdigitated electrical conductor lines may be a straight lines, arced lines, spiral lines, or any other geometric shaped lines. In some non-limiting embodiments or examples, different shapes of

geometric electrical conductor lines may offer advantages of suppressing unwanted spurious modes of the acoustic resonance. In some non-limiting embodiments or examples, the ratio of one or more electrical conductor line(s) to that of one or more piezoelectric line(s) may vary for a given acoustic resonator, which may help to broaden the resonance bandwidth.

In some non-limiting embodiments or examples, the piezoelectric layer can comprise ZnO, AlN, InN, alkali metal and/or alkali earth metal niobate, alkali metal and/or alkali earth metal titanate, alkali metal and/or alkali earth metal tantalite, GaN, AlGaIn, lead zirconate titanate (PZT), polymer, or a doped form of any of the foregoing. The piezoelectric layer may be polycrystalline or monocrystalline. Monocrystalline piezoelectric layer may be formed from a single crystal or from epitaxial growth. In some non-limiting embodiments or examples, the piezoelectric layer may be scandium doped AlN, which may have a higher level of piezoelectric coupling efficiency than undoped AlN.

In some non-limiting embodiments or examples, in a thickness mode of resonance of the acoustic resonator, the piezoelectric layer of the acoustic resonator comprising a layer of diamond as the high acoustic impedance layer can have a coupling efficiency  $\geq 3\%$ ,  $\geq 5\%$ ,  $\geq 7\%$ ,  $\geq 9\%$ ,  $\geq 11\%$ , or  $\geq 13\%$ . In some non-limiting embodiments or examples, in a contour or lateral mode of resonance of the acoustic resonator, the piezoelectric layer of the acoustic resonator comprising a layer of diamond as the high acoustic impedance layer can have a coupling efficiency  $\geq 0.1\%$ ,  $\geq 0.3\%$ ,  $\geq 0.5\%$ ,  $\geq 1.0\%$ ,  $\geq 1.5\%$ ,  $\geq 2.0\%$ ,  $\geq 2.5\%$ ,  $\geq 3.0\%$ ,  $\geq 3.5\%$ ,  $\geq 4.0\%$ , or  $\geq 4.5\%$ .

In some non-limiting embodiments or examples, portions of the piezoelectric layer visible between proximate electrical conductor lines may be removed to form piezoelectric slot(s) in the body of piezoelectric layer. In an example, these piezoelectric slot(s) may reduce feedthrough capacitance ( $C_0$ ) of the acoustic resonator; increase piezoelectric coupling efficiency; or increase  $kT^2$ , where  $kT^2 = C_m/C_0$ , and  $C_m$  is the equivalent motion capacitance. The piezoelectric slot(s) may decouple the piezoelectric response (motion current) and the electric response (direct feedthrough due to capacitive coupling) of the acoustic resonator which may improve a signal-to-noise ratio of the acoustic resonator.

In some non-limiting embodiments or examples, the body of the acoustic resonator may be rectangular, square, circular, annular, ring-shaped, polygon, ellipse, or any other geometric shape. In some non-limiting embodiments or examples, the dimensions of the acoustic resonator may depend on targeted performance(s) such as, for example, insertion loss, power handling capability, thermal dissipation, etc. In some non-limiting embodiments or examples, the largest dimension of the acoustic resonator may be  $\leq 50$  mm,  $\leq 30$  mm,  $\leq 20$  mm,  $\leq 10$  mm,  $\leq 5$  mm,  $\leq 3$  mm,  $\leq 2$  mm, or  $\leq 1$  mm. In an example, the insertion loss of the acoustic resonator may be  $\leq 40$  dB,  $\leq 30$  dB,  $\leq 20$  dB,  $\leq 15$  dB, or  $\leq 10$  dB. To achieve low insertion loss (which can depend on the need of a particular application), the dimensions of the acoustic resonator may be varied (typically, the larger the device, the lower the insertion loss) or by putting multiple acoustic resonators in parallel. The power handling of the acoustic resonator can be  $\leq 70$  dBm,  $\leq 60$  dBm,  $\leq 50$  dBm,  $\leq 40$  dBm,  $\leq 30$  dBm, or  $\leq 20$  dBm.

In some non-limiting embodiments or examples, each acoustic wave reflector can reflect an acoustic wave back toward or into a body of the acoustic resonator when the acoustic wave reaches a boundary of the acoustic resonator.

In some non-limiting embodiments or examples, a single acoustic wave reflector comprising a layer of high acoustic impedance material and, optionally, a layer of low acoustic impedance material may not be able to achieve a desirable acoustic wave reflectance. Therefore, in an example, a multiple acoustic wave reflectors may be used particularly when using condensed-phase materials as high and, optionally, low acoustic impedance layers. In an example, the acoustic reflectance (R) of an acoustic wave may be calculated from the acoustic impedance ( $Z_a$ ) of the layer in which the acoustic wave travels, e.g., the piezoelectric layer, and the acoustic impedance ( $Z_b$ ) of the layer which the travelling acoustic wave reaches, e.g., a high acoustic impedance layer, using the equation:  $R = (Z_b - Z_a) / (Z_a + Z_b)$ .

In an example, to achieve a desired acoustic reflectance, materials having different acoustic impedances may be chosen, or multiple layers of different acoustic impedance materials may be used. The maximum reflection of an acoustic wave can be 100%, if  $Z_b$  is zero, which may occur under the condition of an absolute vacuum. Absent an absolute vacuum,  $Z_b$  will have a numeric value greater than zero. As can be understood from an evaluation of the above equation, the higher the value of  $Z_a$ , the higher the acoustic reflectance (R) of an acoustic wave. Because diamond has one of the highest values (if not the highest value) of acoustic impedance, diamond can be a good material to use as the high acoustic impedance layer of an acoustic wave reflector for reflecting at least part of an acoustic wave produced by the acoustic resonator that reaches the high acoustic impedance layer.

In some non-limiting embodiments or examples, where the bottom electrode has the form of an interdigitated array of electrical conductor lines, acoustic wave energy may be directly transported from the piezoelectric layer into the diamond layer via the spaces or gaps between proximate interdigitated electrical conductor lines. In an example, the spaces or gaps between proximate interdigitated electrical conductor lines can be locations where resonant nodes occur, whereupon minimal acoustic wave transport occurs through these resonant node locations without having to travel through a first reflection interface between the piezoelectric layer and the bottom electrode layer and a second reflection interface between the bottom electrode layer and the high acoustic impedance layer, e.g., diamond. Therefore, in an example, it may be advantageous to have comb-shaped or interdigitated electrode lines between the piezoelectric layer and the high acoustic impedance layer, which can result in an improved quality factor (Q) and/or an improved insertion loss of the acoustic resonator.

In an example, diamond is known to be a low loss material for acoustic wave transport. Under resonant conditions of acoustic waves, diamond can store acoustic wave energy with minimal energy loss (relative to other materials), resulting in a high Q value, which is desirable. An acoustic resonator including an acoustic wave reflector comprising a layer of diamond can have a Q value  $\geq 500$ ,  $\geq 1,000$ ,  $\geq 1,500$ ,  $\geq 2,000$ ,  $\geq 2,500$ ,  $\geq 3,000$ ,  $\geq 3,500$ ,  $\geq 4,500$ , or  $\geq 5,500$ .

Diamond as the material of the high acoustic impedance layer of an acoustic wave reflector can be a good material in avoiding frequency drift of the acoustic resonator as compared to other materials. For achieving an optimal and robust frequency stability over a range of  $-40^\circ$  C. to  $+125^\circ$  C. the acoustic resonator may include one or more temperature compensation layers.

In some non-limiting embodiments or examples, small tether(s) may be used to anchor the acoustic resonator to a supporting structure. The power handling capability of the

acoustic resonator may be increased by increasing the number of tethers. The number of tethers may vary from 1 to 1000 or more. While each tether may be located at any location of the acoustic resonator for anchoring, acoustic wave nodal areas of the acoustic resonator may be desired locations to have tethers that can be used to anchor the acoustic resonator with minimal acoustic wave damping. However, acoustic wave damping cannot be completely eliminated by placing a tether at an acoustic wave nodal area since the tether, though small, is too large to prevent all of the acoustic wave from passing through the tether. Accordingly, in some non-limiting embodiments or examples, a means for reflecting acoustic waves exiting the body of the acoustic resonator via a tether back into said body may be located on a side of the tether opposite the acoustic resonator.

In some non-limiting embodiments or examples, the means for reflecting acoustic can be mirror that may be located on a side of a tether opposite the acoustic resonator. The mirror can be formed of a material having an acoustic impedance  $\leq 65 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ . In an example, the mirror may reflect back  $\geq 20\%$ ,  $\geq 40\%$ ,  $\geq 60\%$ ,  $\geq 80\%$ , or  $\geq 90\%$  of the acoustic wave that is not confined inside the main body of the acoustic resonator. The mirror may be a single layer structure or a multilayered structure having alternating layers of different acoustic impedance materials. In an example, the mirror may comprise a gas phase material or mixture, a liquid phase material, or some combination thereof.

In some non-limiting embodiments or examples, the means for reflecting acoustic waves can be one or more sets of phononic crystals. In an example, each set of phononic crystals may aid in confining  $\geq 20\%$ ,  $\geq 40\%$ ,  $\geq 60\%$ ,  $\geq 80\%$ ,  $\geq 90\%$ ,  $\geq 95\%$ , or  $\geq 99\%$  of the acoustic wave inside the acoustic resonator body. Phononic crystals are known in the art as periodic arrangements of inclusions inside a viscoelastic material or a fluid, for example metal in air, polymer in water, air in epoxy, etc. (See "Phononic crystals and their applications" Pierre-Yves Guerder, Apr. 4, 2011). The number, the shape, the size of these phononic crystals, and their geometric array may vary. The number of phononic crystals in any set of phononic crystals may range from 1 to 1,000,000; 1 to 100,000; 1 to 10,000; 1 to 1,000; or 1 to 100.

In some non-limiting embodiments or examples, phononic crystals can be disposed on a tether to aid in confining the acoustic wave inside the acoustic resonator. The phononic crystal(s) as part of the tether can create a band stop of frequencies that can avoid an acoustic wave from passing through the tether to the supporting structure. In an example, a phononic crystal-derived band stop of frequencies desirably includes the resonant frequency of the acoustic resonator, resulting in avoidance of acoustic energy from passing through the tether and being lost in the supporting structure and suppression of acoustic energy loss, which can result in a higher Q and a lower insertion loss.

#### BRIEF DESCRIPTION OF THE DRAWINGS

These and other features of the present invention will become more apparent from the following description in which reference is made to the appended drawings wherein:

FIG. 1A is an enlarged side view of one non-limiting embodiment or example acoustic resonator in accordance with the principles of the present invention;

FIG. 1B is a perspective view of the example acoustic resonator shown in FIG. 1A;

FIG. 1C is a perspective view of one non-limiting embodiment or example acoustic resonator including tethers in accordance with the principles of the present invention;

FIG. 2A is a plan view of one non-limiting embodiment or example continuous thin film (sheet) electric conductor that can be used as the top electrode, the bottom electrode, or both the top and bottom electrodes of the acoustic resonator shown in FIG. 1C;

FIG. 2B is a plan view of one non-limiting embodiment or example interdigitated electric conductor lines that can be used as the top electrode, the bottom electrode, or both the top and bottom electrodes of the acoustic resonator shown in FIG. 1C;

FIG. 3 is a plan view of one non-limiting embodiment or example acoustic resonator, e.g., similar to the acoustic resonator of any one of FIGS. 1A-1C, including two tethers, one tether at each end, wherein proximate each tether is an acoustic reflector mirror;

FIG. 4 is a plan view of one non-limiting embodiment or example acoustic resonator, e.g., similar to the acoustic resonator of any one of FIGS. 1A-1C, including, for example, a set of five tethers on each end, wherein proximate each set of tethers is a set or array of phononic crystals;

FIG. 5A is a plan view of one non-limiting embodiment or example acoustic resonator, e.g., similar to the acoustic resonator of any one of FIGS. 1A-1C, including two tethers, one tether at each end, wherein each tether includes one or more phononic crystals each configured to operate as a band stop filter;

FIG. 5B is a plan view of one non-limiting embodiment or example acoustic resonator, e.g., similar to the acoustic resonator of any one of FIGS. 1A-1C, that includes multiple tethers on each end, for example, two tethers on the left end and three tethers on the right end, wherein each tether includes one or more phononic crystals each configured to operate as a band stop filter;

FIG. 6 is a plan view of one non-limiting embodiment or example acoustic resonator in accordance with the principles of the present invention including two tethers (one on each end) and sections or arcs of high acoustic impedance layer, e.g., a diamond layer, visible on one or both sides of the acoustic resonator on which there is/are no piezoelectric layer or electrodes;

FIG. 7 is an isolated perspective view of one non-limiting embodiment or example piezoelectric stack including a center piezoelectric layer between a top electrode in the form of a sheet and a bottom electrode which can be in the form of a sheet or interdigitated electrical conductors, wherein portions of the top electrode and the piezoelectric layer include slots formed therein to reduce feedthrough and improve signal-to-noise ratio;

FIGS. 8A-8D are top, side, bottom and end views of an example supporting structure coupled to an example acoustic resonator via a tether, wherein FIG. 8B is a view taken along lines 8B-8B in FIG. 8A, FIG. 8C is a view taken along lines 8C-8C in FIG. 8B, and FIG. 8D is a view taken along lines 8D-8D in FIG. 8A; and

FIGS. 9A-9B are isolated top and side views of an example acoustic resonator coupled (on opposite sides) to a pair of mirror image example supporting structures via a pair of tethers.

#### DESCRIPTION OF THE INVENTION

Various non-limiting examples will now be described with reference to the accompanying figures where like reference numbers correspond to like or functionally equivalent elements.

For purposes of the description hereinafter, the terms “upper”, “lower”, “right”, “left”, “vertical”, “horizontal”, “top”, “bottom”, “lateral”, “longitudinal” and derivatives thereof shall relate to the examples as oriented in the figures. It is to be understood that the invention may assume various alternative variations and step sequences, except where expressly specified to the contrary. It is also to be understood that the specific devices and processes illustrated in the attached drawings, and described in the following specification, are simply exemplary embodiments of the invention. Hence, specific dimensions and other physical characteristics related to the embodiments disclosed herein are not to be considered as limiting.

Referring to FIGS. 1A-1B, in some non-limiting embodiments or examples, an acoustic resonator **100** can comprise a resonator body that has a resonant frequency. Depending on its configuration, the an acoustic resonator **100** may have a resonant frequency  $\geq 1$  MHz;  $\geq 10$  MHz;  $\geq 100$  MHz; 300 MHz;  $\geq 500$  MHz;  $\geq 800$  MHz;  $\geq 1,200$  MHz;  $\geq 1,500$  MHz;  $\geq 1,800$  MHz;  $\geq 2,100$  MHz;  $\geq 2,400$  MHz;  $\geq 2,700$  MHz;  $\geq 3,000$  MHz;  $\geq 3,500$  MHz;  $\geq 4,000$  MHz;  $\geq 4,500$  MHz;  $\geq 5,000$  MHz; or  $\geq 6,000$  MHz. The acoustic resonator **100** may resonate under a fundamental mode or under an overtone mode.

In some non-limiting embodiments or examples, acoustic resonator **100** can comprise a piezoelectric layer **27** that can be disposed between and activated by at least one pair of electrodes, e.g., a top electrode **25** layer and a bottom electrode **35** layer. In a top-down view (shown by arrow **29**), the body of acoustic resonator **100** can be any suitable and/or desirable shape, such as, for example, rectangle, square, circle, annular, ring, polygon, ellipse, or any other geometric shape.

Referring to FIG. 1C and with continuing reference to FIGS. 1A-1B, in some non-limiting embodiments or examples, acoustic resonator **100** may be isolated from the environment via one or more tethers **60**. In an example, each tether **60** may be formed from the same stack of materials as acoustic resonator **100** and can be used to anchor and isolate the body of acoustic resonator **100** from the environment. In an example, the number of the tethers **60** may vary from 1 to 1000 or more. In an example, the use of tether(s) **60** can be optional, depending on the isolation method and the design of an acoustic wave reflector (described in more detail hereinafter).

In some non-limiting embodiments or examples, top electrode **35** may be in contact with the top of piezoelectric layer **27** and bottom electrode **25** may be in contact with the bottom of piezoelectric layer **27**. However, this is not to be construed in a limiting sense. In an example, either electrode or both electrodes **25** and **35** may be a layer of continuous thin film of electrical conductor as shown in FIG. 2A. In another example, either electrode or both electrodes **25** and **35** may comprise a comb-shaped or interdigitated array of thin film electrical conductor(s) as shown in FIG. 2B. In an example, each tether **60** may extend laterally from a side or end of acoustic resonator **100**, i.e., laterally to a stacking direction of bottom electrode **25**, piezoelectric layer **27**, and top electrode **35**. In an example, top electrode **35** may comprise a layer of continuous thin film of electrical conductor (FIG. 2A) and bottom electrode **25** may comprise a comb-shaped or interdigitated array of thin film electrical conductor(s) (FIG. 2B). In another example, bottom electrode **25** may comprise a layer of continuous thin film of electrical conductor (FIG. 2A) and top electrode **35** may comprise a comb-shaped or interdigitated array of thin film electrical conductor(s) (FIG. 2B). However, these configura-

tions of bottom electrode **25** and top electrode **35** are not to be construed in a limiting sense.

In some non-limiting embodiments or examples, for each electrode **25** and/or **35** that comprises a combed-shaped or interdigitated array of thin film electrical conductors, the width **17** of each electrical conductor line **15** and the width **21** of each line of piezoelectric layer **27** visible between proximate electrical conductor lines **15** may vary. A ratio of the width **17** of each electrical conductor line **15** to the width **21** of each line of piezoelectric layer **27** can range from 0.001 to 1,000; 0.01 to 100; or 0.1 to 10, etc. For a pair of proximate comb-shaped or interdigitated electrical conductor lines, the distance between facing sides of said proximate electrical conductor lines may vary, ranging from 1% to 99% of the width **17** of one of said electrical conductor lines **15**. In an example, the ratio of the width **17** of an electrical conductor line **15** to the width **21** of a line of piezoelectric layer **27** between proximate electrical conductor lines **15** may not be uniform for a given device, which may help to broaden the resonance bandwidth.

In some non-limiting embodiments or examples, the conductor lines **15** of the comb-shaped or interdigitated array of thin film electrical conductors may be straight lines, arced lines, spiral lines, or any other shaped geometric lines. Different shapes of geometric lines may offer advantages of suppressing unwanted spurious modes of the acoustic resonances.

In some non-limiting embodiments or examples, acoustic resonator **100** may include, in addition to top electrode **35**, piezoelectric layer **27**, and bottom electrode **25**, one or more of the following: a high acoustic impedance layer **19**, a low acoustic impedance layer **11**, a substrate **50**, and/or one or more optional temperature compensation layers **13**, **23**, and **33** disposed as shown, for example, in FIG. 1A. In another example, one or more optional low acoustic impedance layers **7** and/or one or more optional high acoustic impedance layers **9** may also be provided along with high acoustic impedance layer **19** and/or optional low acoustic impedance layer **11** as shown in FIG. 1A.

In some non-limiting embodiments or examples, low acoustic impedance layer **7** and high acoustic impedance layer **9** can be provided in pairs N and one or more instances of said pairs N can be provided. For example, a single pair N of low acoustic impedance layer **7** and high acoustic impedance layer **9** can be provided as shown in FIGS. 1A-1C. In another example, multiple pairs N of alternating low acoustic impedance layers **7** and high acoustic impedance layers **9** can be provided. For example, in a direction moving upward from substrate **50** toward piezoelectric layer **27**, N pairs of alternating low acoustic impedance layers **7** and high acoustic impedance layers **9** can include a 1<sup>st</sup> low acoustic impedance layer **7**, a 1<sup>st</sup> high acoustic impedance layer **9**, a 2<sup>nd</sup> low acoustic impedance layer **7**, and a 2<sup>nd</sup> high acoustic impedance layers **9**. Additional, pairs N of alternating low acoustic impedance layers **7** and/or high acoustic impedance layers **9** may also be provided atop of 2<sup>nd</sup> high acoustic impedance layer **9** of this example.

In some non-limiting embodiments or examples, the dimensions of acoustic resonator **100** can depend on one or more targeted performances such as insertion loss, power handling capability, thermal dissipation, etc. For example, when used with a hand-held device, e.g., a smartphone, the largest dimension of acoustic resonator **10** can be  $\leq 20$  mm,  $\leq 15$  mm,  $\leq 10$  mm,  $\leq 5$  mm,  $\leq 3$  mm,  $\leq 2$  mm, or  $\leq 1$  mm. In an example, the insertion loss of acoustic resonator **10** used with a hand-held device can be  $\leq 40$  dB,  $\leq 30$  dB,  $\leq 20$  dB, or  $\leq 15$  dB.

In some non-limiting embodiments or examples, when the body of acoustic resonator **100** may have a quadrilateral shape (as viewed in a direction of arrow **29**), the width *W* to length *L* ratio the body of acoustic resonator **100** may vary, from 0.01 to 100; 0.05 to 20; or 0.1 to 10. In an example, each side or end of the body of acoustic resonator **100** does not have to be parallel, or perpendicular to an opposite side or end.

In some non-limiting embodiments or examples, for base station applications and Internet of Things applications (devices around houses, offices, vehicles, etc.), the largest dimension of acoustic resonator **100** can be  $\leq 50$  mm;  $\leq 30$  mm;  $\leq 20$  mm;  $\leq 10$  mm;  $\leq 5$  mm;  $\leq 3$  mm;  $\leq 2$  mm; or  $\leq 1$  mm. In an example, the insertion loss of acoustic resonator **100** used with a base-station device and a device for Internet of Things can be  $\leq 40$  dB;  $\leq 30$  dB;  $\leq 20$  dB;  $\leq 15$  dB; or  $\leq 10$  dB.

In some non-limiting embodiments or examples, to achieve low insertion loss (which can depend on the need of a particular application), the dimensions of acoustic resonator **100** may be varied, typically, the larger the device, the lower the insertion loss. In an example, low insertion loss can also be achieved connecting multiple acoustic resonators **100** in parallel. In an example, the power handling of acoustic resonator **100** can be  $\leq 70$  dBm;  $\leq 60$  dBm;  $\leq 50$  dBm;  $\leq 40$  dBm;  $\leq 30$  dBm; or  $\leq 20$  dBm. In an example, power handling can be improved by using an increased number of tethers **60** to anchor the body of acoustic resonator **100**.

In some non-limiting embodiments or examples, acoustic resonator **100** comprising piezoelectric layer **27**, and at bottom and top electrodes **25** and **35** can further comprise an optional multilayer acoustic wave reflector **37** comprising high acoustic impedance layer **19** (e.g., a diamond film or layer) and, optionally, a low acoustic impedance layer **11**. The illustration in FIGS. 1A-1C of acoustic wave reflector **37** including optional temperature compensation layer **13** is not to be construed in a limiting sense since temperature compensation layer **13** may be omitted.

In some non-limiting embodiments or examples, high acoustic impedance layer **19** can be comprised of diamond. The acoustic impedance of a material is the product of acoustic velocity and the specific density of the material. In an example, acoustic waves can travel very-fast in diamond, about 18,500 m/s. In an example, diamond can have a specific density of 3,500 kg/m<sup>3</sup>. In an example, diamond can have an acoustic impedance of about  $630 \times 10^6$  N·s/m<sup>3</sup>. In some non-limiting embodiments or examples, high acoustic impedance layer **19** can alternatively be comprised of a solid-phase material such as a metal (aluminum, platinum, palladium, tungsten, molybdenum, chromium, titanium, tantalum, or one or more elements from one or more of Group IIIA and/or Group IVA of the periodic table of the elements, or a transition metal from one or more of Group IB, IIB, IIIB, IVB, VB, VIB, VIIIB, and/or VIIIB), ceramic, glass, polymer, etc. In an example, SiC has an acoustic impedance of about  $427 \times 10^6$  N·s/m<sup>3</sup>, Ir has an acoustic impedance of about  $108 \times 10^6$  N·s/m<sup>3</sup>, and W has an acoustic impedance of about  $99.9 \times 10^6$  N·s/m<sup>3</sup>.

In some non-limiting embodiments or examples, optional low acoustic impedance layer **11** may be comprised of a gas-phase material. In an example, the gas-phase material may include one or more of hydrogen, nitrogen, carbon dioxide, carbon monoxide, oxygen, and/or one or more of group VIII inert gases such as helium, neon, argon, krypton, xenon, etc. In another example, the gas-phase material may be an organic material such as a hydrocarbon material or its substituted derivatives with different functional group. In

another example, the gas-phase may be a mixture of any of the foregoing. In another example, other gas material(s) may also work as low acoustic impedance layer **11**, though toxicity and hazard may be an issue. In an example, air may be a suitable gas-phase material or mixture that has a low acoustic impedance, about  $0.0004 \times 10^6$  N·s/m<sup>3</sup>.

In an example, a liquid-phase material may also work as low acoustic impedance layer **11**, for example, water has an acoustic impedance of  $1.48 \times 10^6$  N·s/m<sup>3</sup>.

When a gas-phase or a liquid-phase material is used as low acoustic impedance layer **11** of acoustic wave reflector **37** of acoustic resonator **100**, one or more tether(s) **60** can be used to anchor acoustic resonator **100**. In some non-limiting embodiments or examples, the power handling capability of acoustic resonator **100** may be increased by increasing the number of tethers **60**.

Ceramics, glass, crystals, and minerals may have a low acoustic impedance between  $1 \times 10^6$  N·s/m<sup>3</sup> (such as ivory at  $1.4 \times 10^6$  N·s/m<sup>3</sup>) and  $30 \times 10^6$  N·s/m<sup>3</sup> (such as alumina/sapphire at  $25.5$  N·s/m<sup>3</sup>). Metal has an acoustic impedance between  $1 \times 10^6$  (such as alkali metal K at  $1.4 \times 10^6$  N·s/m<sup>3</sup>) and  $100 \times 10^6$  N·s/m<sup>3</sup> (such as tungsten, W,  $99.72 \times 10^6$  N·s/m<sup>3</sup>) and may, in an example acoustic wave reflector, function as the material of high acoustic impedance layer (e.g., layer **19**), or low acoustic impedance layer (e.g., layer **11**), depending on the selection of the material of the other layer **11** or **19**, respectively. When a condensed-phase material is used as low acoustic impedance layer **11** of acoustic resonator **100**, one or more tether(s) **60** may not needed because isolation of acoustic resonator **100** may not be necessary.

In some non-limiting embodiments or examples, in acoustic resonator **100**, a first material may be used as the high or low acoustic impedance layer depending on the selection of a second material used as the other of the high and low acoustic impedance material. In a general, in acoustic resonator **100**, a material considered to have a high acoustic impedance will have an acoustic impedance greater than a material considered to be a low acoustic impedance material regardless of the specific values of acoustic impedances associated with the high acoustic impedance layer and the low acoustic impedance layer. In some non-limiting embodiments or examples, a value of an acoustic reflectance (*R*) (discussed hereinafter) can be utilized to select appropriate materials to be used as the high acoustic impedance layer and the low acoustic impedance layer.

In some non-limiting embodiments or examples, acoustic wave reflector **37** can reflect acoustic wave(s) generated by piezoelectric layer **27** back into the body of acoustic resonator **100**, comprising at least piezoelectric layer **27** and electrodes **25** and **35**, when said acoustic wave(s) reach(es) a boundary or boundaries of acoustic wave reflector **37**. In an example, acoustic wave reflector **37** can have an acoustic reflectance *R* of  $\geq 50\%$ ,  $\geq 60\%$ ,  $\geq 70\%$ ,  $\geq 80\%$ ,  $\geq 90\%$ ,  $\geq 95\%$ , or  $\geq 99\%$ .

In some non-limiting embodiments or examples, acoustic wave reflector **37** comprising high acoustic impedance layer **19** and optional low acoustic impedance layer **11** may not have a desirable level of acoustic wave reflectance. Accordingly, in an example, a multilayered acoustic wave reflector can be used. An example of a multilayered acoustic wave reflector can include acoustic wave reflector **37** in addition to one or more acoustic wave reflectors **39**, each comprising a high acoustic impedance layer **9** and, optionally, a low acoustic impedance layer **7**. In one non-limiting embodiment or example, a multilayer acoustic wave reflector can include, in the order shown in FIGS. 1A-1C, acoustic wave reflector **37**, comprising high acoustic impedance layer **19**

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and low acoustic impedance layer **11**, and acoustic wave reflector **39**, comprising high acoustic impedance layer **9** and low acoustic impedance layer **7**. One or more additional instances of acoustic wave reflector **39** can be provided below the acoustic wave reflector **39** shown in FIGS. 1A-1C. In an example, the multilayered acoustic wave reflector can be used when condensed-phase materials are used as the high and low acoustic impedance layers. However, this is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, the reflectance (R) of an acoustic wave can be calculated from the acoustic impedance (Za) of the layer in which the acoustic wave travels, e.g., without limitation, piezoelectric layer **27** and/or bottom electrode **25**, and the acoustic impedance of the layer (Zb) which the acoustic wave reaches, e.g., without limitation, high acoustic impedance layer **19**, using the following equation:

$$R = \frac{Zb - Za}{Za + Zb}$$

In some non-limiting embodiments or examples, to achieve desirable acoustic reflectance R, materials having different acoustic impedances may be used, or multiple layers of different acoustic impedances may be used. As can be understood from the above equation, maximum reflection of an acoustic wave is "1" when Zb is "0" (zero), which can occur under conditions of an absolute vacuum. Accordingly, in an example, acoustic resonator **100** can be mounted in a package under a certain level of vacuum which may help achieve better reflectance R of the acoustic wave, possibly resulting in a higher Q.

In some non-limiting embodiments or examples, the value of R may be  $\geq 0.4$ . To achieve this value of R, any materials having suitable values of Za and Zb that are compatible with the process of forming acoustic resonator **100** may be used. Accordingly, the description herein of a material having a high or low acoustic impedance is for the purpose of illustration and is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, if acoustic resonator **100** is not under an absolute vacuum, there can be a numeric value (greater than zero) of acoustic impedance for layer Zb. In this case, the higher the Zb, the higher the reflectance R of the acoustic wave. In an example, diamond is believed to be the material having the highest acoustic impedance Zb, which suggests that diamond may be a good, perhaps best, material to serve the high acoustic impedance layer **19** and/or **9** (when provided) of acoustic wave reflector **37** and/or **39** (when provided) of acoustic resonator **100** that can reflect the acoustic wave via acoustic reflections when the acoustic wave reaches a boundary (e.g., a top surface or a bottom surface of) high acoustic impedance layer **19** and/or **9** (when provided). Hence, acoustic resonator **100** can comprise one or more layers of diamond. The diamond may be monocrystalline or polycrystalline. Polycrystalline diamond may be ultrananocrystalline diamond, nanocrystalline diamond, or microcrystalline diamond.

Diamond is known to be a low loss material for acoustic wave transport. Under resonant conditions of acoustic waves, diamond may store acoustic wave energy with minimal energy loss, resulting in a high and desirable quality (Q) factor. Acoustic resonator **100** comprising one or more of high acoustic impedance layers (**19** and/or **9** (when provided)) can have a  $Q \geq 500$ ,  $\geq 1,000$ ,  $\geq 1,500$ ,  $\geq 2,000$ ,  $\geq 2,500$ ,  $\geq 3,000$ ,  $\geq 3,500$ ,  $\geq 4,500$ , or  $\geq 5,500$ . Other than diamond, other materials that can be used as high acoustic impedance layer(s) in acoustic resonator **100** can have a higher loss for acoustic wave transport.

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In some non-limiting embodiments or examples, it may be desirable that acoustic waves formed by the piezoelectric stack of acoustic resonator **100** get quickly transported into a diamond layer, e.g., layer **19**, resonating inside the diamond layer during resonance, which can lead to a higher Q. In an example, the piezoelectric stack of acoustic resonator **100** can include piezoelectric layer **27**, top electrode **35**, and bottom electrode **25**. Each of top electrode **35** and bottom electrode **25** can each have any suitable and/or desirable form or pattern such as, without limitation, a continuous thin film of electrical conductor, a comb-shaped or interdigitated pattern, etc.

In some non-limiting embodiments or examples, at least one layer of electrode (top electrode **35** and/or bottom electrode **25**) may be needed to activate piezoelectric layer **27**. In an example, bottom electrode **25** under piezoelectric layer **27** may (undesirably) serve as a reflection layer for the acoustic wave generated by piezoelectric layer **27**, preventing or reducing the acoustic wave that is generated by piezoelectric layer **27** from travelling into high acoustic impedance layer **19**. In an example, it, therefore, may be desirable for bottom electrode **25** between piezoelectric layer **27** and high acoustic impedance layer **19** to comprise a comb-shaped or interdigitated array of electrical conductor lines, as shown in FIG. 2B, or other geometric shapes that allow less reflection of the acoustic waves back to the piezoelectric stack that can have a higher loss of the acoustic wave energy. In this manner, acoustic wave energy from the piezoelectric stack can travel into or be transported into high acoustic impedance layer **19** among the gaps or spaces **27** of the comb-shaped or interdigitated electrical conductor lines.

In some non-limiting embodiments or examples, space(s) between proximate comb-shaped or interdigitated electrical conductor lines of bottom electrode **25**, can be locations where resonant nodes occurs. Therefore, minimum amounts of acoustic waves can be transported through these nodal areas without having to pass through a first reflection interface between piezoelectric layer **27** and bottom electrode **25**, and a second reflection interface between bottom electrode **25** and high acoustic impedance layer **19**. Therefore, it can be desirable for bottom electrode **25** to have a comb-shaped or interdigitated array of electrical conductor lines **15** between piezoelectric layer **27** and diamond layer **19**.

In some non-limiting embodiments or examples, while each tether **60** may be located at any location of acoustic resonator **100** for anchoring, an acoustic wave nodal area can be a desirable location for a tether **60** that can be used to anchor acoustic resonator **100** with minimal reduction in acoustic wave damping. However, acoustic wave damping may not be completely eliminated by placing a tether **60** at an acoustic wave nodal area since the tether **60**, though small, is of sufficient size to allow some acoustic wave to pass through, resulting in a lower Q, which is not desirable.

In some non-limiting embodiments or examples, acoustic resonator **100** can optionally include any one or combination of one or more temperature compensation layers **13**, **23** and/or **33** positioned as shown in FIGS. 1A and 1B. In some non-limiting embodiments or examples, acoustic resonator **100** can include multiple high and, optionally, low acoustic impedance layers **9** and **7**, in addition to high acoustic impedance layer **19** and, optionally, low acoustic impedance layer **11**. In an example, each low acoustic impedance layer **7** can be formed from the same or a different material than each other low acoustic impedance layer(s) **7** and/or **11**. Similarly, each high acoustic impedance layer **9** can be

formed from the same or different material than each other high acoustic impedance layer(s) **9** and/or **19**.

In some non-limiting embodiments or examples, when acoustic resonator **100** is used as a radio-frequency or microwave electromagnetic wave filter and/or as an oscillator, it is desirable for the resonant frequency of acoustic resonator **100** to be robust, or stable, as the environment changes in temperature. However, the resonant frequency can change when the environment temperature changes, which is known as frequency drift,  $\Delta f/f$ , between temperatures of  $-40^\circ\text{C}$ . and  $125^\circ\text{C}$ ., which is not desirable.

In an example, diamond by itself can be a good material in avoiding temperature-based frequency drift as compared to other materials. However, achieving optimal and robust resonant frequency over a range of  $-40$  to  $+125^\circ\text{C}$ . may require acoustic resonator **100** to include one or more temperature compensation layers **13**, **23**, and **33**. Each temperature compensation layer can comprise silicon dioxide, a silicon element, and/or an oxygen element. In an example, one or more temperature compensation layer(s) may be below diamond layer **19**, above diamond layer **19**, below bottom electrode **25**, above piezoelectric layer **27**, and/or above top electrode layer **35**. Examples of temperature compensation layers **13**, **23**, and **33** are shown in FIGS. 1A and 1B. The thickness of any temperature compensation layer may be  $\leq 30$  microns,  $\leq 20$  microns,  $\leq 10$  microns,  $\leq 1$  micron, or  $\leq 0.4$  microns. In some non-limiting embodiments or examples, the frequency drift of acoustic resonator **100** for every degree C. of temperature change can be  $\leq 1000$  ppm/ $^\circ\text{C}$ .,  $\leq 500$  ppm/ $^\circ\text{C}$ .,  $\leq 300$  ppm/ $^\circ\text{C}$ .,  $\leq 100$  ppm/ $^\circ\text{C}$ .,  $\leq 50$  ppm/ $^\circ\text{C}$ .,  $\leq 30$  ppm/ $^\circ\text{C}$ .,  $\leq 20$  ppm/ $^\circ\text{C}$ .,  $\leq 10$  ppm/ $^\circ\text{C}$ ., or  $\leq 5$  ppm/ $^\circ\text{C}$ .

In some non-limiting embodiments or examples, piezoelectric layer **27** of acoustic resonator **100** can be activated by the application of a radio reference (Rf) signal applied between top and bottom electrodes **35**, **25**.

In some non-limiting embodiments or examples, piezoelectric layer **27** can be comprised of ZnO, AlN, InN, alkali metal and/or alkali earth metal niobate, alkali metal and/or alkali earth metal titanate, alkali metal and/or alkali earth metal tantalite, GaN, AlGaIn, lead zirconate titanate (PZT), polymer, or a doped form of a piezoelectric layer that is described above.

In some non-limiting embodiments or examples, piezoelectric layer **27** formed of scandium doped AlN may offer a higher level of piezoelectric coupling efficiency than undoped AlN. In an example, however, piezoelectric layer **27** formed of scandium doped AlN may suffer in other material properties such as, for example, without limitation, a reduction in acoustic velocity which may adversely affect attaining resonant frequency, an increase in acoustic wave energy loss, and/or an increase in dielectric constant which can lead to a higher level of feedthrough (leading to a lower signal-to-noise ratio). In addition, doping of AlN forming piezoelectric layer **27** may also lead to acoustic resonator **100** dissipating more energy at resonant frequency, which can lead to a lower Q.

In some non-limiting embodiments or examples, an advantage of acoustic resonator **100** comprising at least one acoustic wave reflector **37** and/or **39** comprising at least one layer of diamond is that it helps avoid the above-mentioned disadvantages when using Sc-doped AlN for piezoelectric layer **27**, or any doped piezoelectric layer, or any piezoelectric layer that may have a high coupling efficiency. In an example, piezoelectric layer **27** having a high coupling efficiency can be lossy (i.e., dissipate more energy) when resonating and can have a low acoustic velocity. In an

example, diamond is known to be a low acoustic loss material and can have a high acoustic velocity, for example, the highest acoustic velocity of known materials. Acoustic resonator **100** comprising piezoelectric layer **27** having a high level of piezoelectric effect (coupling efficiency), such as Sc-doped AlN piezoelectric layer, and comprising at least one acoustic wave reflector **37** and/or **39** comprising a layer of diamond can achieve a high Q and high frequency resonance at the same time. The piezoelectric layer for acoustic resonator **100** comprising at least one acoustic wave reflector **37** and/or **39** comprising at least one layer of diamond can have a coupling efficiency  $\geq 3\%$ ,  $\geq 5\%$ ,  $\geq 7\%$ ,  $\geq 9\%$ ,  $\geq 11\%$ , or  $\geq 13\%$  while operating in a thickness mode. The piezoelectric layer for acoustic resonator **100** comprising at least one acoustic wave reflector **37** and/or **39** comprising at least one layer of diamond while operating in a contour mode or in a lateral mode can have a coupling efficiency  $\geq 0.1\%$ ,  $\geq 0.3\%$ ,  $\geq 0.5\%$ ,  $\geq 1.0\%$ ,  $\geq 1.5\%$ ,  $\geq 2.0\%$ ,  $\geq 2.5\%$ ,  $\geq 3.0\%$ ,  $\geq 3.5\%$ ,  $\geq 4.0\%$ , or  $\geq 4.5\%$ .

The thickness of piezoelectric layer **27** can be between 10 nm and 1000 microns; or between 20 nm and 500 microns; or between 30 nm and 100 microns; or between 40 nm and 50 microns; or between 50 nm and 20 microns; or between 60 nm and 10 microns. The ratio of the thickness of diamond layer **19** or **9** to the thickness of the piezoelectric layer **27** may be  $>10,000$ ;  $>1,000$ ;  $>100$ ;  $>50$ ;  $>20$ ;  $>10$ ;  $>1$ ; or  $>0.1$ . Piezoelectric layer **27** may cover a surface of diamond layer **19** completely, or partially, for example  $\geq 10\%$ ,  $\geq 30\%$ ,  $\geq 50\%$ ,  $\geq 70\%$ ,  $\geq 80\%$ , or  $\geq 90\%$ .

Piezoelectric layer **27** may be polycrystalline or monocrystalline. Monocrystalline piezoelectric layer may be from a single crystal or from an epitaxial growth.

Next described are some non-limiting embodiments or examples of reducing acoustic wave loss using tethers **60** for an improvement in Q and, possibly, a reduction in insertion loss.

With reference to FIG. 3 and with continuing reference to all previous figures, in some non-limiting embodiments or examples, in plain view, acoustic resonator **100** can have top electrode **35** in the form of a comb-shaped or interdigitated array of electrical conductor lines **15** and can have a main body **102** that can be at least partially isolated from the surrounding environment by one or more tethers **60**.

In some non-limiting embodiments or examples, a means for reflecting acoustic waves can be located on the side of a tether **60** opposite main body **102**. In some non-limiting embodiments or examples, the means for reflecting acoustic waves can be a mirror **202**, e.g., a straight mirror, (shown in phantom in FIG. 3) or a curved mirror (shown in solid line in FIG. 3). The illustration of a curved mirror and a straight mirror proximate each tether **60** in FIG. 3 is for illustration purposes and is not to be construed in a limiting sense since it is envisioned that only single mirror **202**, albeit a straight mirror or a curved mirror, may be disposed proximate each tether **60**.

In some non-limiting embodiment or examples, each mirror **202** can be made from any suitable and/or desirable low acoustic impedance material now known or hereinafter developed. In an example, each mirror **202** can be comprised of a low acoustic impedance solid-phase material; a low acoustic impedance gas-phase material, a low acoustic impedance liquid-phase material, or some combination thereof that is/are compatible with the materials forming acoustic resonator **100** and/or a supporting structure to which acoustic resonator **100** and/or each mirror **202** may be coupled or mounted.

In some non-limiting embodiments or examples, the profile of the curved mirror **202** in FIG. **3** may be circular, parabolic, hyperbolic, etc., with the aim of maximizing reflection of an acoustic wave exiting main body **102** by each tether **60** back to the main body **102** which may increase the Q of acoustic resonator **100** and/or which may possibly lower insertion loss.

In some non-limiting embodiments or examples, each mirror **202** may be a multilayered structure including alternating layers of different acoustic impedance materials, e.g., materials **204** and **206**. In an example, materials **204** and **206** may be gas-phase and solid-phase materials, or vice versa. However, this is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, a shortest distance **64** of mirror **202** to a distal end **63** of a tether **60** can be  $\frac{1}{8}$  (or more) of the wavelength of the acoustic wave produced in use of acoustic resonator **100**. The inside diameter of a circular mirror **202** can be  $\frac{1}{8}$  (or more) of the wavelength of the acoustic wave produced in use of acoustic resonator **100**. A major and/or minor axis length of a parabolic or a hyperbolic mirror can be  $\frac{1}{8}$  (or more) of the wavelength of the acoustic wave produced in use of acoustic resonator **100**. The aim of using a mirror **202** as a means for reflecting acoustic waves, albeit a straight mirror or a curved mirror, is to reflect back  $\geq 20\%$ ,  $\geq 40\%$ ,  $\geq 60\%$ ,  $\geq 80\%$ , or  $\geq 90\%$  of the acoustic wave that is not confined inside main body **102** in use of acoustic resonator **100**.

With reference to FIG. **4** and with continuing reference to all previous figures, in some non-limiting embodiments or examples, in plan view, acoustic resonator **100** can have its main body **102** isolated and anchored by a plurality of tethers **60**, e.g., ten tethers **60**, to one or more supporting structures **400** (shown in phantom). Supporting structure(s) **400** in FIG. **4** can be a single piece or element coupled to tethers **60** at separate locations or each tether **60** can be coupled to a separate supporting structure **400**. The illustration and locations of supporting structure(s) **400** in FIG. **3** is/are for example only and is not to be construed in a limiting sense. For the purpose of description, FIG. **4** will be considered as having two separate supporting structures **400** positioned laterally to a stacking direction of bottom electrode **25** layer, piezoelectric layer **27**, and top electrode **35** layer. However, this is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, acoustic resonator **100** can have a plurality of spaced parallel electrical conductor lines **15**, e.g., five spaced electrical conductor lines **15**, that run from one end of main body **102** to the other end. However, is not to be construed in a limiting sense since the use of other quantities, geometries, and layouts of separate electrical conductor lines **15**, e.g., the interdigitated electrical conductor lines **15** discussed above, is envisioned. In the example shown in FIG. **4**, portions of piezoelectric layer **27** are visible between each pair of proximate electrical conductor lines **15** and proximate the sides **104** of main body **102**. However, this is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, the means for reflecting acoustic waves can be a group, set, or array **302** of phononic crystals **304** that can be formed in a supporting structure **400** coupled to the ends of one or more tethers **60** opposite main body **102**. In an example, a first electrode **306** can be used to connect two tethers **60** on one side of main body **102** to one supporting structure **400** that includes one array of phononic crystals **304** while a second electrode **308** on the other side of main body **102** can be used to connect three tethers **60** to a second supporting structure **400** that includes another array of phononic crystals **304**. An

example supporting structure **400** that can be used or adapted for use in the various non-limiting embodiments or examples described herein will be described hereinafter.

In some non-limiting embodiments or examples, the number, shape, size, and/or arrangement of phononic crystals **304** in each array **302** can vary. In an example, the number of phononic crystals in each array **302** can range from 1 to 1,000,000; 1 to 100,000; 1 to 10,000; 1 to 1,000; or 1 to 100. A shortest distance **66** between a distal end **63** of a tether **60** of and one or more phononic crystals **304** can be  $\frac{1}{8}$  (or more) of the wavelength produced in use of acoustic resonator **100**. The aim of phononic crystals **304** is to help confine the acoustic wave produced in use of acoustic resonator **100** to main body **102** for the purpose of attaining a superior Q, and possibly a lower insertion loss. In an example, phononic crystals **304** can confine  $\geq 20\%$ ,  $\geq 40\%$ ,  $\geq 60\%$ ,  $\geq 80\%$ ,  $\geq 90\%$ ,  $\geq 95\%$ , or  $\geq 99\%$  of the acoustic wave inside of main body **102**.

FIGS. **5A-5B**, show two different plan views of non-limiting embodiment or example acoustic resonators **100** that can be anchored by two tethers **60** (FIG. **5A**) (one tether **60** on each end) and five tethers **60** (FIG. **5B**) (two tethers on the left end and three on the right end). In some non-limiting embodiments or examples, each tether **60** can include one or more phononic crystal(s) **304** at part of the structure of the tether **60** itself that can act as one or more band stop filters. The ends of each tether **60** opposite main body **102** can be coupled or connected to a supporting structure **400** (shown in phantom). An example of a supporting structure **400** will be described hereinafter.

In some non-limiting embodiments or examples, the phononic crystal(s) **304** of each tether **60** can help confine the acoustic wave produced in use of acoustic resonator **100** to main body **102**. The number of phononic crystal(s) **304** of each tethers **60** can range from 1 to 1,000,000; to 100,000; 1 to 10,000; 1 to 1,000; 1 to 100; 1 to 20; or 1 to 10.

In some non-limiting embodiments or examples, the shape of phononic crystals **304** can be square, rectangle, polygon, circle, ellipse, ring, annular, or any other geometric shape. In some non-limiting embodiments or examples, combinations of different shaped phononic crystals **304** maybe used. Each phononic crystal **304** can include one or more open holes, or one or more holes filled with other material, such as material having different acoustic impedance than the material(s) forming the phononic crystal **304**.

In some non-limiting embodiments or examples, the phononic crystal(s) **304** of each tether **60** can create a band stop of frequencies that are stopped by said phononic crystal(s) **304**. In an example, the band stop frequencies of the phononic crystal(s) **304** can include the resonance frequency of acoustic resonator **100**. The aim of phononic crystals **304** is to help confine at least a portion of the acoustic wave produced in use of acoustic resonator **100** to main body **102** for the purpose of attaining a superior Q, and possibly a lower insertion loss.

In some non-limiting embodiments or examples, the phononic crystal(s) **304** of each tether can help reduce acoustic wave energy loss to the supporting structure **400**. Some or all of tethers **60** of acoustic resonator **100** can include one or more phononic crystal(s) **304** for achieving a band stop at a desired frequency. Accordingly, the illustration in FIGS. **5A-5B** of each tether **60** including six phononic crystal(s) **304** is not to be construed in a limiting sense.

With reference to FIG. **6**, in some non-limiting embodiments or examples, a supporting structure **400** can be coupled to each tether **60** of acoustic resonator **100**. As shown in FIG. **6**, for example, acoustic resonator **100** can

have interdigitated electrical conductor lines **15**. However, this is not to be construed in a limiting sense. In an example, acoustic resonator **100** may include, proximate sides **104** of main body **102**, one or more optional areas or portions **41** of high acoustic impedance layer **19** (e.g., diamond) that face upward that may be exposed as shown in the plan view of FIG. 6, i.e., no portion of top electrode **35**, piezoelectric layer **27**, or bottom electrode **25** (i.e., piezoelectric stack) are atop of the upward facing portion(s) **41** of high acoustic impedance layer **19**. In an example, the exposed, upward facing portion(s) **41** of high acoustic impedance layer **19** may be arc shaped, bulging further away from the side(s) of the piezoelectric stack (which may have the rectangular shape shown in FIG. 6) intermediate the ends **106** of main body **102** and gradually arcing toward ends **106** of main body **102**. It is believed that having the arc shaped, upward facing portions **41** of high acoustic impedance layer **19** exposed (not covered by portions of the piezoelectric stack) may increase the Q of acoustic resonator **100** and/or may improve the insertion loss of acoustic resonator **100**.

This illustration in FIG. 6 of the combination of supporting structure **400** and acoustic resonator having areas or portions **41** that are exposed and are shaped bulging further away from the sides of the piezoelectric stack is not to be construed in a limiting sense since supporting structure **400** and each portion **41** may be provided and used independently of each other.

In some non-limiting embodiments or examples, some or all of the supporting structure(s) **400** may include mirror **202** (albeit a curved or straight mirror) and/or one or more phononic crystals **304**. Mirror **202** and/or one or more phononic crystals **304** may be included on a surface of or embedded in the body of each supporting structure **400** in any manner deemed suitable and/or desirable by one skilled in the art. An example of a supporting structure **400**, including an optional mirror **202** or one or more phononic crystals **304**, connected to a single tether **60** will be described hereinafter with reference to FIG. 8A-8D.

FIG. 7 shows a non-limiting embodiment or example isolated portion of acoustic resonator **100** including a piezoelectric stack comprising piezoelectric layer **27**, top electrode layer **35** above piezoelectric layer **27**, and bottom electrode layer **25** below piezoelectric layer **27**.

An acoustic wave reflector comprising at least a high acoustic impedance layer **19** and, optionally, a low acoustic impedance layer **11** and, optionally, one or more of high and/or low acoustic impedance layers **9** and **7** can be positioned under the piezoelectric stack.

In some non-limiting embodiments or examples, high acoustic impedance layer **19** can comprise a layer of diamond. In some non-limiting embodiments or examples, acoustic resonator **100** may also comprise one or more temperature compensation layer(s) **13**, **23**, and/or **33** (FIGS. 1A-1C).

In the example shown in FIG. 7, portions of piezoelectric layer **27** between proximate electrical conductor lines **15** of top electrode layer **35** can be removed to form one or more slots **28** in the body of piezoelectric layer **27**. It is believed that these one or more slots **28** may reduce feedthrough capacitance ( $C_o$ ) of acoustic resonator **100**, whereupon the anti-resonance frequency changes according to the reduction in the value of  $C_o$ , which can lead to an increase in

piezoelectric coupling efficiency, or an increase in  $kT^2$ ; where  $kT^2=C_m/C_o$ ; and  $C_m$  is the equivalent motion capacitance. This can allow another degree of freedom to decouple the piezoelectric response (motion current) and the electric response (direct feedthrough due to the capacitive coupling) which can result in an improved signal to noise ratio.

In some non-limiting embodiments or examples, diamond can be one of the most thermally conductive materials known, having a thermal conductivity up to 2000 watts per meter per degree Kelvin, which can make it desirable for applications in thermal management under demanding conditions, for example, optoelectronics, electronics, semiconductor, etc., for devices handling high power in communications and other applications. Diamond can also have a low coefficient of thermal expansion (CTE), which can make it versatile for uses in temperature sensitive applications (such as temperature-related frequency drift in RF communications). Diamond can also be a desirable optical material for transmitting radio frequency electromagnetic wave, microwave, infrared, visible, and other ultraviolet electromagnetic waves. Diamond can also have high stability when used as detector for high fluence nuclear radiation. Diamond can also be highly inert in chemical environment(s) that can involve strong acid, strong base, strong oxidizing agent, or strong reducing agent, even at elevated temperatures or at cryogenic conditions, which can make diamond compatible with different harsh process chemicals. Diamond can also have a high refractive index, which can lead to its use in the jewelry industry and in electromagnetic wave management.

In some non-limiting embodiments or examples, the acoustic velocity for diamond can be 18,500 m/s, which is much higher than that for single crystal silicon (8,500 m/s) and/or silicon carbide (13,300 m/s), as shown in Table 1, below. Acoustic velocity is an intrinsic material property that can be used in making an acoustic resonator. Acoustic resonators are widely used as RF filters, an RF oscillators, RF MEMS switches, and microsystems (sensor). The resonance frequency of an acoustic resonator, e.g., any example acoustic resonator **100** described herein, can be directly proportional to the acoustic velocity of the material forming high acoustic impedance layer **19** and inversely proportional to the geometric dimension of the acoustic resonator or the feature size of acoustic resonator.

In some non-limiting embodiments or examples, acoustic resonator **100** (with a given geometry) that includes diamond as the material of high acoustic impedance layer **19** can resonate at a frequency that is 2.2 times of that of an acoustic resonator made of silicon as the material of high acoustic impedance layer **19**. In an example, for a given resonant frequency, an acoustic resonator **100** made of diamond as the material of high acoustic impedance layer **19** can have one or more critical geometric dimensions, e.g., the pitch size of the interdigitated fingers, that can be about 2.2 times smaller than the critical geometric dimension of an acoustic resonator made of silicon as the material of high acoustic impedance layer **19**. An acoustic resonator made of diamond as the material of high acoustic impedance layer **19** can also have lower energy loss during vibration, as compared to an acoustic resonator made of silicon as the material of high acoustic impedance layer **19**, which can be measured by the Q. The theoretical Q for diamond is around 380,000, as compared to that for silicon, which is around 36,000. The higher the Q value, the lower the energy loss is during vibration.

TABLE 1

Comparison of Acoustic Velocities and Theoretically Predicted Quality Factors at 1 GHz and 3 GHz*			
Material	$v_a$ (m/S)	Q Theory @ 1 GHZ	Q Theory @ 3 GHZ
Diamond	18,500	380,000	380,000
SiC	13,300	320,000	116,000
Quartz	5,720	39,000	13,000
Si	8,500	36,000	36,000
AlN	10,970	8,700	3,400

In some non-limiting embodiments or examples, diamond as the material of high acoustic impedance layer **19** of acoustic resonator **100** can be grown atop of another layer of acoustic resonator **100** in a reactor via chemical vapor deposition (CVD), where suitable growth conditions can be achieved by microwave-enhanced plasma, tungsten hot-filament, DC-Jet plasma, laser-induced plasma, acetylene-torch, etc. CVD is well known in the art and will not be described further herein.

In some non-limiting embodiments or examples, acoustic resonator **100** having diamond as the material of high acoustic impedance layer **19** can be configured to have both a high quality diamond body and a high quality diamond surface, which can facilitate acoustic resonator **100** having a higher resonant frequency, a higher Q value, or both.

In some non-limiting embodiments or examples, the upward facing surface of diamond as the material of high acoustic impedance layer **19**, e.g., the surface facing piezoelectric layer **27**, can be finished optically smooth for use as a sound wave medium, such as, for example, as an acoustic wave reflector to transport and reflect acoustic waves, or to conduct heat energy away from an electronic device.

In some non-limiting embodiments or examples, there can be a mismatch in coefficient of thermal expansion between diamond (about  $1 \times 10^{-6}$  m/m-K) as the material of high acoustic impedance layer **19** of acoustic resonator **100** and the silicon (about  $3 \times 10^{-6}$  m/m-K) that may be material of substrate **50** of acoustic resonator **100**.

For the purpose of description only, substrate **50** may be described as being formed of silicon. However, this is not to be construed in a limiting sense, since it is envisioned that substrate **50** may be formed of any material, now known or hereinafter discovered, deemed suitable and/or desirable by one skilled in the art.

In some non-limiting embodiments or examples, diamond as the material of high acoustic impedance layer **19** of acoustic resonator **100** may be grown, e.g., via CVD, directly on the silicon forming substrate **50** of acoustic resonator **100**. In another example, diamond as the material of high acoustic impedance layer **19** of acoustic resonator **100** may be grown on one or more layers of material formed or deposited above the silicon forming substrate **50** (such as, for example, without limitation, one or more of low acoustic impedance layer **7**, high acoustic impedance layer **9**, low acoustic impedance layer **11**, and/or temperature compensation layer **13**) prior to growth of the diamond forming high acoustic impedance layer **19**.

In some non-limiting embodiments or examples, acoustic resonator **100** can be formed with any one or more or none of optional layers **7**, **9**, **11**, **13**, **19**, **23**, and **33** shown, for example, in FIGS. 1A-1C. Hence, the illustration in FIGS. 1A-1C of acoustic resonator **100** including optional layers **7**, **9**, **11**, **13**, **19**, **23**, and **33** is not to be construed in a limiting sense.

Hereinafter, "diamond layer" and "high acoustic impedance layer" may sometimes be used interchangeably. However, this is not to be construed in a limiting sense since high acoustic impedance layer may be formed of one or more other materials other than diamond.

With reference back to FIG. 1A, in some non-limiting embodiments or examples, acoustic resonator **100** may comprise substrate **50** made of silicon, e.g., a silicon wafer, and high acoustic impedance material **19** made of CVD grown diamond, wherein an interface **8** between diamond layer **19** and a proximate underlying layer can be optically finished or physically dense with a substantially absence of voids or gaps among the diamond grains. For a lapped, grounded or etched surface on which diamond layer **19** is grown to form interface **8** which can be characterized by the presence of voids or gaps among the diamond grains of diamond layer **19**, which can be characterized by its diamond grain density. In an example, the diamond grain density of diamond layer **19** at interface **8** may be  $\geq 10^4/\text{cm}^2$ ,  $\geq 10^5/\text{cm}^2$ ,  $\geq 10^6/\text{cm}^2$ ,  $\geq 10^7/\text{cm}^2$ ,  $\geq 10^8/\text{cm}^2$ , or  $\geq 10^9/\text{cm}^2$ . The surface roughness (Ra) of the material or layer on which diamond layer **19** is directly grown, e.g., temperature compensation layer **13**, low acoustic impedance layer **11**, substrate **50**, etc., may be  $\leq 100$  nm,  $\leq 50$  nm,  $\leq 30$  nm,  $\leq 20$  nm,  $\leq 10$  nm,  $\leq 5$  nm,  $\leq 2$  nm, or  $\leq 1$  nm. In an example, this surface roughness (Ra) may be determined prior to growth of diamond layer **19**. In some non-limiting embodiments or examples, a dense diamond layer **19** can enable acoustic wave transport therethrough with minimal wave scattering, versus a diamond layer **19** which is porous which may dampen acoustic wave transport therethrough, e.g., via wave scattering.

In some non-limiting embodiments or examples, the bottom surface **10** of diamond layer **19** at interface **8** may be optically finished after exposing bottom surface **10** of diamond layer **19** or by growth of diamond layer **19** on a top surface of a layer that itself has an optically finished surface. The surface roughness (Ra) of the bottom surface **10** of diamond layer **19** may be  $\leq 100$  nm,  $\leq 50$  nm,  $\leq 30$  nm,  $\leq 20$  nm,  $\leq 10$  nm, or  $\leq 5$  nm. In some non-limiting embodiments or examples, the bottom surface **10** of diamond layer **19** at interface **8** may be physically dense with a substantial absence of voids or gaps among the diamond grains.

In some non-limiting embodiments or examples, an optically finished bottom surface **10** can allow precision control of the geometric dimension of acoustic resonator **100**, which in-turn can control an intrinsic acoustic resonance frequency of acoustic resonator **100** (a critical parameter for a RF communication filter, or oscillator, etc.).

In some non-limiting embodiments or examples, acoustic resonator **100** having a dense layer of diamond at interface **8** can avoid acoustic wave scattering and an optically finished bottom surface **10** can allow precision control of acoustic wave reflection. In thermal management, a dense layer of diamond at interface **8** can avoid slow heat conduction in the gas-phase or in a vacuum in the voids or gaps among the diamond grains, taking advantage of fast phonon transport in the diamond material, thereby improving thermal management, which can allow improved power handling in RF communications.

In some non-limiting embodiments or examples, top surface **14** of diamond layer **19** may be optically finished, e.g., by a polishing process prior to forming layers over top surface **14**. The surface roughness (Ra) of top surface **14** can be  $\leq 100$  nm,  $\leq 50$  nm,  $\leq 30$  nm,  $\leq 20$  nm,  $\leq 10$  nm, or  $\leq 5$  nm. The optical finish of top surface **14** can be a factor in acoustic wave management for precision control of geomet-

ric dimensions, and can enable successful growth of a highly oriented bottom electrode **25** and/or piezoelectric layer **27** which can aid in piezoelectric coupling for acoustic wave resonance.

In some non-limiting embodiments or examples, a top surface of the layer of material on which diamond layer **19** is grown (e.g., the top surface of substrate **50**, or the top surface of low acoustic impedance layer **19**, or temperature compensation layer **13**) can be optically finished or dense prior to growth of diamond layer **19** thereon, whereupon bottom surface **10** of diamond layer **19** can, at least in part, inherit the optical finish from said top surface layer of material during growth of diamond layer **19** thereon.

In some non-limiting embodiments or examples, high acoustic impedance layer **19** (e.g., made of diamond) of acoustic resonator **100** may be any thickness. In some non-limiting embodiments or examples, the thickness of high acoustic impedance layer **19** may be  $\leq 5$  microns,  $\leq 10$  microns,  $\leq 20$  microns,  $\leq 50$  microns,  $\leq 100$  microns,  $\leq 200$  microns,  $\leq 500$  microns, or  $\leq 2,000$  microns. In an example, the thickness of high acoustic impedance layer **19** may be dictated by the precision needed in acoustic wave resonance, light transport control, and/or efficiency in thermal management.

In some non-limiting embodiments or examples, substrate **50** (e.g., made of silicon) of acoustic resonator **100** may be any thickness. In some non-limiting embodiments or examples, the thickness of substrate **50** can be  $\geq 10$  microns,  $\geq 50$  microns,  $\geq 100$  microns,  $\geq 200$  microns,  $\geq 500$  microns,  $\geq 2,000$  microns, or  $\geq 5,000$  microns. The thickness of substrate **50** can be dictated by the needs of applications and the practical needs during the process of fabricating acoustic resonator **100**.

In some non-limiting embodiments or examples, substrate **50** of acoustic resonator **100** may be a layer of silicon, e.g., a silicon wafer, that may be undoped or doped, p-type or n-type, monocrystalline or polycrystalline. Said silicon layer can be cut from any crystal direction. Different types of silicon may also be selected for use as the material of substrate **50** for acoustic wave management. For example, in one application, high-electric-resistance silicon may be selected for use as the material of substrate **50**. In another example, electrically conductive silicon may be selected, as needed, for use as the material of substrate **50**. In yet another application, a single crystal or polycrystalline silicon may be selected for use as the material of substrate **50**.

In some non-limiting embodiments or examples, where a silicon wafer is used as substrate **50**, said silicon wafer may have any geometric (largest) dimension. In an example, the largest dimension silicon wafer (e.g., diameter) can be  $\geq 25.4$  mm,  $\geq 50.8$  mm,  $\geq 76.2$  mm,  $\geq 101.6$  mm,  $\geq 127$  mm, or  $\geq 152.5$  mm. The diameter of the silicon wafer may be selected and controlled so it can be handled in different fabrication processes.

In some non-limiting embodiments or examples, acoustic resonator **100** can have a total thickness of  $\geq 50$  microns,  $\geq 100$  microns,  $\geq 150$  microns,  $\geq 250$  microns,  $\geq 500$  microns,  $\geq 1$  mm,  $\geq 3$  mm, or  $\geq 5$  mm. The thickness of acoustic resonator **100** can be dictated by the fabrication process to meet specific application needs.

In some non-limiting embodiments or examples, high acoustic impedance layer **19** formed of a layer of diamond, i.e., diamond layer **19**, may be undoped or doped, p-type or n-type, of a quality with Raman half-height-peak-width of  $\leq 20$   $\text{cm}^{-1}$ ,  $\leq 15$   $\text{cm}^{-1}$ ,  $\leq 10$   $\text{cm}^{-1}$ , or  $\leq 7$   $\text{cm}^{-1}$ . Diamond layer **19** may be polycrystalline, nanocrystalline, or ultrananocrystalline. Doped and conductive diamond layer **19** may be

used for a capacitive-driven acoustic resonator **100**. Doped and conductive diamond layer **19** may be used as an electrode material of a high-frequency-high Q resonance media for acoustic wave management. The quality of diamond layer **19** may also be selected to achieve a desired level of intrinsic acoustic velocity and low power loss in acoustic resonance. The quality of diamond layer **19** may also affect the thermal conductivity, dictated by the needs in thermal applications, particularly for power handling for a device in RF communications.

In some non-limiting embodiments or examples, the silicon wafer forming substrate **50** may have an aspect ratio of  $\geq 5$ ,  $\geq 10$ ,  $\geq 15$ ,  $\geq 20$ , or  $\geq 30$ , where the aspect ratio is defined as the ratio of the longest or largest geometric dimension (such as diameter) over thickness.

Referring to FIGS. **8A-8D** and with continuing reference to all previous figures, in some non-limiting embodiments or examples, an example supporting structure **400** may be connected to an example acoustic resonator **100** via tether **60**. In an example, acoustic resonator **100** can include, from top-to-bottom, a stack comprising top electrode **35**, piezoelectric layer **27**, bottom electrode **25**, and diamond layer **19**. Tether **60** can be comprised of the same layers of material as acoustic resonator **100** but, as shown in FIGS. **8A** and **8C**, tether **60** can be formed and have a width that is narrower than the width  $W$  of the side or end of acoustic resonator **100**.

In an example, acoustic resonator **100** (including tether **60**) and supporting structure **400** may be formed as a unitary piece by sequentially depositing on substrate **50**: diamond layer **19**, bottom electrode **25**, piezoelectric layer **27** and top electrode **35**. Tether **60** can be formed by the selective removal (etching) of portions of top electrode **35**, piezoelectric layer **27**, bottom electrode **25** and diamond layer **19** on opposite sides of tether **60**, before or after removal (etching) of substrate **50** from below acoustic resonator **100** and below tether **60**. In an example, the width of tether **60** can be formed following the completion of the deposition and etching steps used to define the features of acoustic resonator **100** and supporting structure **400** discussed hereinafter. However, this is not to be construed in a limiting sense.

In some non-limiting embodiments or examples, the example supporting structure **400** can include top electrode **35a**, piezoelectric layer **27a**, bottom electrode **25a**, and diamond layer **19a** corresponding to and formed at the same time of the same materials as top electrode **35**, piezoelectric layer **27**, bottom electrode **25**, and diamond layer **19** of acoustic resonator **100** and tether **60**. The use of suffixes, e.g., "a", with reference numbers in connection with the discussion of the example supporting structure **400** of FIGS. **8A-8D** is to facilitate describing the features of supporting structure **400** compared to the features of acoustic resonator **100** and tether **60** and is not to be construed in a limiting sense.

As can be seen in FIGS. **8A** and **8C**, the width  $W$  of supporting structure **400** can be wider than the width of tether **60** and the width of acoustic resonator **100**. However, this is not to be construed in a limiting sense since it is envisioned that each of supporting structure **400** and acoustic resonator **100** can have any suitable and/or desirable width including the same width.

As shown in FIGS. **8B** and **8D**, in some non-limiting embodiments or examples, the end of supporting structure **400** opposite tether **60** can include (retain) a portion of substrate **50** on a bottom of diamond layer **19a** opposite bottom electrode **25a**. The portion of substrate **50** shown in FIGS. **8B** and **8D** can be what remains after etching away

substrate **50** from the entire bottoms of acoustic resonator **100** and tether **60**, and etching away substrate **50** from the portion of the bottom of supporting structure **400** proximate tether **60**.

In some non-limiting embodiments or examples, a mirror image of supporting structure **400** shown connected to tether **60** on the right side of acoustic resonator **100** in FIG. **8A** can be connected to the tether **60** on the other (left side) of acoustic resonator **100** shown in FIG. **8A**. This other supporting structure **400** is not shown for simplicity of illustration and discussion.

In some non-limiting embodiments or examples, as shown in FIGS. **8C** and **8D**, during formation of supporting structure **400** and prior to depositing the piezoelectric material that is used to form piezoelectric layers **27** and **27a**, a portion of bottom electrode **25a** can be selectively removed (etched away) forming a space **26** (shown in phantom in FIG. **8D** and as shown outlined by dashed line **30** in FIG. **8C**) that can define electrode arms **25a1** and **25a2** on opposite sides of supporting structure **400** and extensions **62** of electrode arms **25a1** and **25a2** that can be connected to bottom electrode **25** of tether **60** and acoustic resonator **100**.

In an example, the piezoelectric material forming piezoelectric layers **27** and **27a** can then be deposited, for example, in space **26** (on top of the portions of diamond layer **19a** exposed by the removal of the portion of bottom electrode **25a** from space **26**) and on top of electrode arms **25a1** and **25a2**, extensions **62**, and bottom electrode **25** of tether **60** and acoustic resonator **100**.

In some non-limiting embodiments or examples, to facilitate top side electrical connections to bottom electrode arms **25a1** and **25a2** after formation of piezoelectric layer **27a** in space **26** and on top of electrode arms **25a1** and **25a2**, one or more via holes **63a** and **63b** may be formed through piezoelectric layer **27a** in vertical alignment with portions of bottom electrode arms **25a1** and **25a2**, respectively. In an example, shown in FIGS. **8B** and **8D**, the one or more via holes **63a** and **63b** may be formed proximate the end of piezoelectric layer **27a** opposite tether **60**. However, this is not to be construed in a limiting sense.

Next, during the formation or deposition of the metal used to form top electrodes **35** and **35a**, said metal can be deposited on piezoelectric layers **27** and **27a** and into via holes **63a** and **63b** thereby forming contacts with the electrode arms **25a1** and **25a2** of bottom electrode **25a**. At this point in the formation of acoustic resonator **100** and supporting structure **400**, the metal forming top electrodes **35** and **35a** is a continuous layer.

In some non-limiting embodiments or examples, the metal forming top electrodes **35** and **35a** can then be selectively removed (etched) to form (as shown in FIG. **8A**) the pattern of interdigitated fingers of acoustic resonator **100**, the electrical arm **35a1** connected to one set of the interdigitated fingers, and one or more top electrode pads **35a2** and **35a3** in contact with electric arms **25a1** and **25a2** by way of via holes **63a** and **63b** respectively.

In an example, top electrode **35a1** can be utilized to apply electrical stimulus to one set of the interdigitated fingers while the one or more electrode pads **35a2** and **35a3** can be utilized to apply electrical stimulus to bottom electrode **25** (e.g., in the form of a sheet) of acoustic resonator **100** via one or both arms **25a1** and **25a2** and extensions of bottom electrode **25a** of supporting structure **400**. As can be appreciated, a mirror image of supporting structure **400** connected to the other tether **60** (on the left side in FIG. **8A**) of acoustic resonator **100** can be formed in a similar manner and can be

connected to the other set of interdigitated fingers of acoustic resonator **100** and, optionally, to bottom electrode **25**.

In some non-limiting embodiments or examples, as described above, each supporting structure **400** can include mirror **202**, one or more phononic crystals **304**, or both that can act as a means for reflecting **70** acoustic waves (shown in phantom in FIG. **8B**) exiting acoustic resonator **100** back into acoustic resonator. In an example, means for reflecting **70** acoustic waves can be embedded at least in piezoelectric layer **27a**. However, this is not to be construed in a limiting sense since it is envisioned that the means for reflecting **70** acoustic waves can also be included in one or more other layers of supporting structure **400**, such as, for example, diamond layer **19a** via piezoelectric material **27a** in space **26**.

Next, a non-limiting embodiment or example method of fabricating acoustic resonator **100** and supporting structure **400** coupled to each tether **60** will be described. Initially, diamond layer **19** is deposited on substrate **50**. A layer of bottom electrode **25** material can then be deposited on a side of diamond layer **19** opposite substrate **50**. Next, the bottom electrode **25** of each supporting structure **400** is etched to form arms **25a1** and **25a2**, extensions **62**, and space **25b** between arms **25a1** and **25a2** shown in FIG. **8D**. Next, piezoelectric material is deposited on bottom electrode **25**, on top of the conductive material forming arms **25a1** and **25a2**, in space **26** therebetween, and on top of extensions **62** to form piezoelectric layers **27** and **27a**.

Next, via holes **63a** and **63b** are formed in piezoelectric layer **27a** to enable top side electrical contact with arms **25a1** and **25a2**. Top electrode **35** material is then deposited over piezoelectric layers **27** and **27a**, and in via holes **63a** and **63b**. This top electrode **35** material is then patterned and etched to form the interdigitated fingers of acoustic resonator **100**, and contacts **35a1**, **35a2**, and **35a3**, wherein the material of top electrode **35** forming contacts **35a2** and **35a3** extends through via holes **63a** and **63b** into contact with arms **25a1** and **25a2**.

Etching is then performed (in one or more steps) on top electrode **35**, piezoelectric layer **27**, bottom electrode **25**, and diamond layer **19** to define each tether **60** that couples a supporting structure **400** acoustic resonator **100**.

Referring to FIGS. **9A-9B** and with continuing reference to FIGS. **8A-8D**, substrate **50** beneath acoustic resonator **100**, each tether **60**, and the portion of each supporting structure **400** proximate acoustic resonator **100** can be removed at any time deemed suitable and/or desirable, for example, after forming each tether **60**. However, this is not to be construed in a limiting sense.

Removing substrate **50** from beneath acoustic resonator **100** and each tether **60**, and removing the portion of each supporting structure **400** proximate acoustic resonator **100** releases acoustic resonator **100** from substrate **50**, whereupon acoustic resonator **100** is held in suspension by at least two supporting structures **400** (e.g., one supporting structure **400** on each side of acoustic resonator **100**) via tethers **60** and the un-etched substrate **50** proximate the ends of the supporting structures **400** opposite acoustic resonator **100** shown in FIG. **9B**. In other words, acoustic resonator **100** is suspended in space and held fixed in said space by at least a pair of supporting structures **400** via corresponding tethers **60**.

In some non-limiting embodiments or examples, substrate **50** can be removed (etched) from at least beneath acoustic resonator **100**, from beneath each tether **60**, beneath the portion of each supporting structure **400** proximate acoustic resonator **100**, and along the sides thereof as shown inside

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of dashed box 72 in FIG. 9A. Outside of dashed box 72, the material forming substrate 50 can remain. The shape and/or location of dashed box 72 is/are not to be construed in a limiting sense.

An advantage of suspending acoustic resonator in space via tethers 60 is that it allows acoustic resonator 100 to resonate unconstrained by contact with additional materials, other than via tethers 60. In an example, the space surrounding the acoustic resonator can be air, a gas-phase material or mixture, or some level of vacuum. Diamond layer 19 and the air, gas-phase material, or mixture, or vacuum in the space surrounding acoustic resonator 100 can constitute respective high and low acoustic impedance layers 19 and 11. In an example, these high and low acoustic impedance layers can have an acoustic reflectance of 0.9999. High acoustic reflectance may be achieved by use of multiple acoustic wave reflectors, e.g., 37 and 39, each of which can include at least a layer of a high acoustic impedance material and an optional layer of a low acoustic impedance material.

In another example, the piezoelectric layer(s) of tether 6 and/or supporting structure 400 area may act as a dielectric. Accordingly, in an example, these piezoelectric layer(s) can be replaced by any dielectric material, which may be useful in suppressing undesirable parasitic loss of acoustic wave energy.

The invention has been described with reference to various examples which are shown for the purpose of illustration and not limitation. Modification and alterations to the described examples are envisioned. For example, the use of interdigitated fingers on the top surface of any example acoustic resonator is not to be construed in a limiting sense since it is envisioned that electrical stimulus can be applied to the top surface of acoustic resonator 100 and a signal extracted from acoustic resonator 100 in any suitable and/or desirable manner using any suitable and/or desirable structure. Hence, the examples herein of the top surface of any example acoustic resonator including one or more pairs of spaced elongated fingers is not to be construed in a limiting sense. Finally, the various features described herein and illustrated in the figures may be combined or mixed in any manner deemed suitable and/or desirable.

The invention claimed is:

1. An acoustic resonator comprising:

a piezoelectric stack comprising:

a piezoelectric layer having on opposite sides thereof a top surface and a bottom surface;

a top electrode layer disposed above the top surface; and

a bottom electrode layer disposed below the bottom surface; and

a plurality of acoustic wave reflectors disposed on a side of the bottom electrode layer opposite the piezoelectric layer, each acoustic wave reflector including a high acoustic impedance layer having an acoustic impedance  $(Z_a) \geq 60 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ , wherein the high acoustic impedance layer of at least one of the acoustic wave reflectors is a layer of diamond.

2. The acoustic resonator of claim 1, wherein at least one of the acoustic wave reflectors includes a low acoustic impedance layer having an acoustic impedance  $(Z_b)$  on a side of its high acoustic impedance layer opposite the bottom electrode layer, and the acoustic impedances  $Z_a$  and  $Z_b$  have values that satisfy the equation:

$$|(Z_b - Z_a)/(Z_a + Z_b)| \geq 0.4.$$

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3. The acoustic resonator of claim 2, wherein the low acoustic impedance layer has an acoustic impedance  $\leq 65 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ .

4. The acoustic resonator of claim 2, wherein the low acoustic impedance layer is vacuum or a gas-phase material or mixture.

5. The acoustic resonator of claim 4, wherein the gas-phase material or mixture includes one or more of the following: air, hydrogen, nitrogen, carbon dioxide, carbon monoxide, oxygen, helium, neon, argon, krypton, and xenon.

6. The acoustic resonator of claim 2, wherein the low acoustic impedance layer is a solid-phase material.

7. The acoustic resonator of claim 6, wherein the solid-phase material comprises at least one of the following: ceramic, glass, crystal, and/or mineral.

8. The acoustic resonator of claim 1, wherein the high acoustic impedance layer is comprised of metal, ceramic, glass, or polymer.

9. The acoustic resonator of claim 8, wherein the metal comprises one or more elements from one or more of the following Groups of the periodic table of the elements: IIIA, IVA, IB, IIB, IIIB, IVB, VB, VIB, VIIB, and VIIIB.

10. The acoustic resonator of claim 1, further including at least one temperature compensation layer, the at least one temperature compensation layer disposed at least at one of the following locations:

between the bottom electrode layer and at least one of the acoustic wave reflectors;

on a side of at least one of the high acoustic impedance layers opposite the bottom electrode layer; and/or

on a side of the top electrode layer opposite the piezoelectric layer.

11. The acoustic resonator of claim 10, wherein each temperature compensation layer includes an element comprising silicon, an element comprising oxygen, or both.

12. The acoustic resonator of claim 1, wherein the acoustic resonator is coupled to at least one supporting structure disposed laterally to a stacking direction of the layers of the piezoelectric stack.

13. The acoustic resonator of claim 12, further including a tether coupling a side or end of the acoustic resonator to the supporting structure.

14. An acoustic resonator, comprising:

a piezoelectric stack comprising:

a piezoelectric layer having on opposite sides thereof a top surface and a bottom surface;

a top electrode layer disposed above the top surface; and

a bottom electrode layer disposed below the bottom surface; and

a plurality of acoustic wave reflectors disposed on a side of the bottom electrode layer opposite the piezoelectric layer, each acoustic wave reflector including a high acoustic impedance layer having an acoustic impedance  $(Z_a) \geq 60 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ ,

wherein at least one of the acoustic wave reflectors includes a low acoustic impedance layer having an acoustic impedance  $(Z_b)$  on a side of its high acoustic impedance layer opposite the bottom electrode layer, and the acoustic impedances  $Z_a$  and  $Z_b$  have values that satisfy the equation:

$$|(Z_b - Z_a)/(Z_a + Z_b)| \geq 0.4; \text{ and}$$

wherein the low acoustic impedance layer is a liquid-phase material.

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15. The acoustic resonator of claim 14, wherein the high acoustic impedance layer of at least one of the acoustic wave reflectors is a layer of diamond.

16. An acoustic resonator, comprising:

a piezoelectric stack comprising:

- a piezoelectric layer having on opposite sides thereof a top surface and a bottom surface;
- a top electrode layer disposed above the top surface; and
- a bottom electrode layer disposed below the bottom surface; and

a plurality of acoustic wave reflectors disposed on a side of the bottom electrode layer opposite the piezoelectric layer, each acoustic wave reflector including a high acoustic impedance layer having an acoustic impedance  $(Z_a) \geq 60 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ ,

wherein the acoustic resonator is coupled to at least one supporting structure disposed laterally to a stacking direction of the layers of the piezoelectric stack, and wherein the acoustic resonator, further includes:

- a tether coupling a side or end of the acoustic resonator to the supporting structure; and
- a means for reflecting acoustic waves disposed on a side of the tether opposite the acoustic resonator.

17. The acoustic resonator of claim 16, wherein the tether has a width less than a width of the side or end of the acoustic resonator.

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18. The acoustic resonator of claim 16, wherein the means for reflecting acoustic waves includes a mirror formed of a material having an acoustic impedance  $\leq 65 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ .

19. The acoustic resonator of claim 16, wherein the means for reflecting acoustic waves includes one or more phononic crystals.

20. An acoustic resonator comprising:

a piezoelectric stack comprising:

- a piezoelectric layer having on opposite sides thereof a top surface and a bottom surface;
- a top electrode layer disposed above the top surface; and
- a bottom electrode layer disposed below the bottom surface; and

a plurality of acoustic wave reflectors disposed on a side of the bottom electrode layer opposite the piezoelectric layer, each acoustic wave reflector including a high acoustic impedance layer having an acoustic impedance  $(Z_a) \geq 60 \times 10^6 \text{ N}\cdot\text{s}/\text{m}^3$ ,

wherein the acoustic resonator is coupled to at least one supporting structure disposed laterally to a stacking direction of the layers of the piezoelectric stack, and wherein the acoustic resonator, further includes:

- a tether coupling a side or end of the acoustic resonator to the supporting structure; and
- one or more phononic crystals included in the tether.

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